

FORM PTO-1390 (REV 11-2000)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE	ATTORNEY'S DOCKET NUMBER WSP:203-US
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371			U.S. APPL. NO. (IF KNOWN, SEE 37 CFR 1.5) 10/049559
INTERNATIONAL APPL. NO. PCT/EP00/06604	INTERNATIONAL FILING DATE 12 July 2000	PRIORITY DATE CLAIMED 16 August 1999	
TITLE OF INVENTION DEVICE FOR THE PRODUCTION OF PLASTIC CONTAINERS BY STRETCH BLOW FORMING USING AN EXPLOSIVE BLOWING MEDIUM			
APPLICANT(S) FOR DO/EO/US CHATARD, Dominique et al.			

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☐ This is an express request to promptly begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (21) indicated below.
4. ☐ The U.S. has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☐ is attached hereto (required only if not communicated by the International Bureau).
 - b. ☒ has been communicated by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).
 - a. ☒ is attached hereto
 - b. ☐ has been previously submitted under 35 U.S.C. 154(d)(4).
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☐ are attached hereto (required only if not communicated by the International Bureau).
 - b. ☐ have been communicated by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)) (UNSIGNED)
10. ☐ An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A FIRST preliminary amendment.
14. ☐ A SECOND or SUBSEQUENT preliminary amendment.
15. ☐ A substitute specification.
16. ☐ A change of power of attorney and/or address letter. (3 separate forms)
17. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821-1.825.
18. ☐ A second copy of the published international application under 35 U.S.C. 154(d)(4).
19. ☐ A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).
20. ☒ Other items of information: **Certificate of Mailing with Express Mail Mailing Label No. ET700370606US**

U.S. APPLN. NO. (if known, see 37 CFR 1.53) 10/049559		INTERNATIONAL APPLN. NO. 111111 PCT/EP00/06604		ATTORNEY'S DOCKET NUMBER WSP:203-US	
21. <input checked="" type="checkbox"/> The following fees are submitted:				CALCULATIONS PTO USE ONLY	
BASIC NATIONAL FEE (37 CFR 1.492(a)(1) - (5): Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO. . . . \$1000.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO \$860.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$710.00 International preliminary examination fee paid to USPTO (37 CFR 1.482) but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$690.00 International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(1)-(4) \$ 100.00					
ENTER APPROPRIATE BASIC FEE AMOUNT =				\$ 860.00	
Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input checked="" type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				\$	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE		
Total claims	15 - 20 =	0	X \$18.00	\$ 0.00	
Independent claims	2 - 3 =	0	X \$80.00	\$ 0.00	
MULTIPLE DEPENDENT CLAIM(S) (if applicable)			+ \$270.00	\$ 0.00	
TOTAL OF ABOVE CALCULATIONS =				\$	
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27. The fees indicated above are reduced by 1/2.				\$	
SUBTOTAL =				\$ 860.00	
Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f)).				\$	
TOTAL NATIONAL FEE =				\$ 860.00	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property +				\$	
TOTAL FEES ENCLOSED =				\$ 860.00	
				Amount to be:	\$
				refunded	
				charged	\$


- a. ☒ A check in the amount of \$ 860.00 to cover the above fees is enclosed.
- b. ☐ Please charge my Deposit Account No. in the amount of \$ to cover the above fees. A duplicate copy of this sheet is enclosed.
- c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 04-1790. A duplicate copy of this sheet is enclosed.
- d. ☐ Fees are to be charged to a credit card. **WARNING:** Information on this form may become public. **Credit card information should not be included on this form.** Provide credit card information and authorization on PTO-2038.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

SEND ALL CORRESPONDENCE TO:

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DATED: February 14, 2002


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25,330
 REGISTRATION NUMBER

Express Mail Mailing Label No. ET700370606US

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PRELIMINARY AMENDMENT

Commissioner for Patents
Washington, D.C. 20231

Sir:

Please amend the above-identified patent application as follows:

IN THE CLAIMS

Please cancel original Claims 2-13 and substitute the following new Claims 14-27:

14. A device for forming a deformable plastic material blank (2), having an open end (7), into a mold having an internal space shaped to correspond to a desired shape of a container (1); said device comprising:

a receiving portion (4) for holding and sealing to said open end (7), said receiving portion having a receiving portion axial channel for accommodating a movable stretching die (11);

a distributor module (14) having a module axial channel for accommodating a movable stretching die (11), said distributor module (14) engaging the receiving portion (4) in a fluid tight seal so that the receiving portion axial channel and module axial channel are axially aligned and so that the distributor module and receiving portion together have a device-side interior space (22), said distributor module further

having at least one connector for at least one fluid line to connect the fluid line to the device-side interior space;

a movable stretching die (11) arranged to be guided axially through the receiving portion axial channel and the module axial channel;

a metering unit;

at least one tubular line connected between the metering unit and said at least one connector of the distributor module, said tubular line being closable to seal the device-side interior space;

a heating means for heating the blank (2) to render it readily deformable;

an ignitor (12) positioned within the device-side interior space for igniting an explosive gas mixture within the blank (2); and

a cooling means for cooling a finished container.

15. A device according to Claim 14 wherein the receiving portion (4) has, at an end opposite the container (1), an annular sealing surface (19) through which the stretching die (11) is movably passed, axially extending the receiving portion (4).

16. A device according to Claim 14 wherein the closing means for sealing off the device-side interior space (22) is a check valve (23).

17. A device according to Claim 14 wherein the stretching die (11) is hollow and has at least one outlet aperture (20) arranged on a stretching die tip, at least one fluid inlet (21) and at least one internal channel (39) connecting aperture (20) and inlet (21).

18. A device according to Claim 17 wherein a check valve (23) is located within stretching die (11) proximate outlet aperture (20).

19. A device according to Claim 18 wherein the ignitor (12) is fitted in the hollow stretching die (11) between check valve (23) and outlet aperture (20) and is oriented to

stop flow from the aperture (20) to inlet (21) and the ignitor is electrically connected by means of a cable (36) running in the hollow stretching die (11) to a control unit.

20. A device according Claim 14 wherein the stretching die (11) is a steel tube (34) with a cap-shaped stretching die tip on which the fluid outlet (20) is fitted in a hole and the check valve (23) is provided with a valve body (37) movable with respect to a sealing seat (38) fitted inside the steel tube (34).

21. A device according to Claim 14 wherein a means is provided for moving receiving portion (4) perpendicular to its longitudinal central axis (13).

22. A device according to Claim 14 wherein the receiving portion (4) is widened at an end opposite distributor module (14) to form a service space (5) in which a centering ring (6) is fitted.

23. A device according to Claim 14 wherein an axially movable hollow piston (17) is arranged in the distributor module (14), said piston being provided with an annular opposing sealing surface (18) fitting a sealing surface (19) of the receiving portion (4).

24. A device according to Claim 23 wherein a seal (16) is fitted into a base of the distributor module (14) around the piston (17).

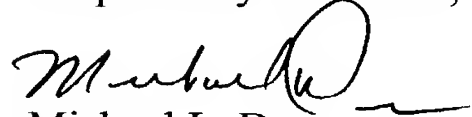
25. A device according to Claim 14 wherein at least one supply line and at least one drainage line, connected to the metering unit, are connected to the distributor module (14).

26. A device according to Claim 14 wherein each of the supply lines and drainage lines are connected to the distributor module (14) are connected to a check valve (23), and the ignition means (12) is fitted in the distributor module (14).

27. A device according to Claim 14 wherein the hollow piston (17) is provided with an annular seat (47, 48) on an end facing the receiving portion (4), and the stretching die (11) carries a radially widened portion (46) perpendicular to its longitudinal axis (13) on an end movable into the container to be manufactured for engagement with the sealing seat.

Dated: February 14, 2002

Respectfully submitted,



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MLD/csc

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10/049559
JC13 Rec'd PCT/PTO 14 FEB 2002
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Device for manufacturing plastics containers by means of stretch blow forming

The invention relates to a device for manufacturing containers from a plastics material which can be formed by stretch-blowing, with a mould, the internal space of which corresponds to the finished container, which is held by its open end by a receiving portion, wherein lines connected to a metering unit are provided on the receiving portion, a moveable stretching die is guided through the receiving portion, and an ignition means is arranged in order to ignite an explosive gas mixture inside the container, and wherein heating and cooling means are provided.

A device of the type described hereinabove for manufacturing plastics containers, for example bottles from polyethylene terephthalate (PET) is known from international published document number WO98/06559. These PET bottles are manufactured in that firstly a blank is heated to a temperature suitable for stretch blowing, of approximately 100 - 120°C. This blank is inserted into a tooling mould corresponding to the shape of the container, and a stretching pressure of at least 2 bar, normally of 5 - 10 bar, is produced. With the aid of an axially, and in general vertically, moveable stretching die, the blank is stretched axially. Then, a blowing pressure is produced in the blank, which is in the region of 40 bar. In this way the wall of the blank is pressed against the inside wall of the mould, and in this way the container is formed. While the stretching pressure is created by blowing an explosive gas mixture into the blank, for example a mixture of oxyhydrogen gas and an inert gas, the blowing pressure is created by igniting the explosive gas mixture, and this blowing pressure presses the wall of the intermediate form, or respectively the partly pre-formed container, completely against the inside wall of the mould. In this way the PET bottle is produced. The ignition of the explosive gas mixture is done by a spark generator or an emission, and the explosive gas mixture is a mixture of an oxidising agent and a component which can be oxidised such as, for example, hydrogen, methane or the like. In the same process of stretching and blowing, by achieving a brief increase in temperature, sterilisation of the container to be manufactured is possible, so this technique is considered very advantageous.

It has been shown, however, that when converted to technology, the containers manufactured with the known device could not be used industrially. They could not be manufactured and were not reproducible with sufficient quality with respect to shape and volume, and also with respect to their optical appearance. It was, for example, not possible to manufacture PET bottles with clearly transparent walls. To the extent that it was not caused intentionally or could be accounted for for specific reasons, it was thought that this sometimes unattractive appearance was due to unavoidable effects of temperature.

10 The object of the invention is thus to provide a device of the type described in the introduction, with the aid of which plastics containers with a better appearance, for example with largely clearly transparent walls, can be manufactured without large additional expenditure.

15 This object is solved in accordance with the invention in that, on its end facing the container, the receiving portion can be engaged in a flowable medium-tight manner with a distribution module, through which module the stretching die is moveably guided in the axial direction, extending the receiving portion, and on which at least one connector for flowable media is fitted, in that the at least one connector for
20 flowable media can be closed for sealing the device-side interior space, and in that ignition means is fitted in the device-side interior space. During the manufacturing process, the receiver is, in one stage, in sealed engagement with the distributor module, and in the other stage is disengaged from the distributor module. In the stretching stage, the stretching die is moveably guided through the distributor
25 module and thereby also axially through the receiving portion.

In the case of one embodiment of the invention, a device-side interior space is formed by the parts of the device fitted together, these being the distributor module, receiving portion and the container located in the mould. With this embodiment, a
30 flowable medium is conducted through the at least one connector for flowable media into the distributor module, and through this into the receiving portion and the container.

continuous process for manufacturing only three to six containers, sufficient reaction product was still not formed in the device-side interior space, for example the supply and drainage lines, so there were hardly any water droplets present to cloud the internal walls of the container. With a longer continuous manufacturing process, because of the large number of successive explosions over time, there was, however, a large enough amount of reaction product (water) such that with each following explosion clouding of the container walls was unavoidable.

The closing off of a small device-side interior space, which is formed only from the interior space of the distributor module, the receiving portion and the container itself, in particular does not allow any accumulation of the unwanted reaction product (water), in that at least container itself, and preferably from the container and receiving portion is removed after the explosion, and thereby the accumulated reaction product as well. Insignificant amounts of reaction product therefore remain in the remaining device-side interior space which, even in a continuous manufacturing process, can still be ignored after a long period.

By means of this change in the construction technique of the device, it is unexpectedly possible to manufacture, without a large cost increase, plastics containers with a better appearance, in the case of PET bottles having largely clearly transparent walls.

The invention is further advantageously configured, in that the receiving portion is hollow and is provided in its end facing the container with a sealing surface through which the stretching die is conducted moveably in the axial direction extending the receiving portion. The receiving portion is preferably hollow so that the stretching die can be moved through the whole elongately configured receiving portion from one of its ends axially to its opposite end. At the same time, the receiving portion can be connected to the distributor module in a flowable medium-tight manner by means of the sealing surface which extends around the space for the stretching die, and is thus annular. It is advantageous when the stretching die is guided through this annular sealing surface in a flowable medium-tight manner so that optionally a

flowable medium, preferably gases, can be forced from the distributor module through the receiving portion into the container to be manufactured, without the gases getting outside the device. By means of the hollow configuration of the receiving portion, not only can the stretching die be guided through into the container and drawn out of it again, but flowable media can also be conducted
5 between the external surface of the stretching die and the internal surface of the receiving portion into the container, and additionally the volume inside the receiving portion is kept relatively small. In particular, the space provided for the explosion can be limited to the device-side interior space described, ensuring that chemical
10 reactions do not place in the supply lines when reaction products occur.

It is furthermore advantageous according to the invention when the closing means for sealing off the device-side interior space is a non-return valve. Non-return valves are known per se in many various configurations. A non-return valve can be
15 fitted to each connector of the distributor module when the embodiment is selected in which the distributor module belongs to the device which provides the device-side interior space. Another configuration of non-return valve can also be provided in addition or alternatively on the stretching die, optionally even in the stretching die, as will be described hereinafter with reference to a preferred embodiment. The
20 device-side interior space, in the case of an advantageous embodiment, is formed by the container to be manufactured and the receiving portion, when this assembly can, for example, be separated from the distributor module.

It is further advantageous in accordance with the invention when the stretching die is
25 configured hollow and is provided with at least one outlet aperture arranged on a stretching die tip, at least one flowable medium inlet, and with at least one internal channel connecting them, and when preferably in the area of the outlet aperture there is fitted a non-return valve. In the case of the hollow stretching die described here, the non-return valve is thus located in the stretching die, and thereby in the area of
30 the outlet aperture. Stretching dies for the stretch blowing process are known per se.

The preheated blank is stretched with the aid of the respective stretching die in that its stretching die tip engages with the base of the blank, and pushes it away. In the

case of the embodiment being considered here, it is possible to arrange an internal channel in the longitudinal direction of the stretching die such that the flowable medium can be pushed from its supply-side end to the opposite side in the direction towards the stretching die tip, and out of the outlet aperture. With this embodiment,
5 at least one gas can be transported through the internal channel in the hollow stretching die into the space inside the container to be produced, as the flowable medium at the outlet aperture adjacent to the stretching die tip can be brought directly into the volume of the container.

10 With another embodiment, in addition to the flowable medium inlet with an internal channel in the hollow stretching die described, connectors for flowable media can be provided, for example, on the distributor module, so that different gases can be supplied through different lines. In this embodiment too, it is always ensured that in the supply lines no combustion, and therefore no chemical reactions, can take place
15 when, for example, the explosive gas is ignited in the volume of the container to be manufactured.

In a preferred embodiment, before ignition of the explosive gas mixture, the non-return valve in the hollow stretching die is closed. Combustion cannot take place
20 then in the internal channel in the hollow stretching die. Because the supply and drainage lines for the flowable medium, preferably for the gases, are closed and separated from the device-side interior space before the explosion, the volume for the chemical reaction, particularly for combustion, is entirely limited to the device-side interior space. With smaller amounts of flowable media involved in the
25 combustion, smaller amounts of reaction products also occur, so advantageously there is little fear of damaging or affecting the internal surfaces of the container to be manufactured. In this way, the appearance of the container walls can be considerably improved. Moreover, all the advantages of the known stretch-blowing process can be made use of, including sterilisation by combustion.

30

It is further advantageous according to the invention when in the area of the outlet aperture an ignition means is fitted inside the hollow stretching die on the side of the

non-return valve facing away from the outlet aperture, and preferably is electrically connected via cables or conductor pathways to a control unit. The ignition of the explosive mixture of flowable media can take place almost in the centre of the container to be manufactured, using such a design for the hollow stretching die.

5 Parts of the device set further outside the container can then be disengaged or closed according to the process. The actuation of the ignition means via the cable or conductive pathway also takes place advantageously through the hollow configuration of the stretching die. The connection of the non-return valve causes no interference, but instead it is preferably selected such that the whole internal
10 channel in the hollow stretching die can be separated by means of the non-return valve from the explosion space, namely by closing the non-return valve.

In a further advantageous configuration of the invention, the hollow stretching die, which is driven such that it is moveable in the longitudinal direction, is a steel tube
15 with a cap-shaped stretching die tip on which the flowable medium outlet is provided as a hole structure, wherein the non-return valve is provided with a valve body movable with respect to a sealing seat fitted inside the steel tube, and preferably carrying turbulence producing means. The hollow stretching die can in practice be made from a steel tube of stainless steel, the stretching die tip of which is
20 nevertheless provided with a cap which is exchangeable, and consequently matching the properties of the respective blanks to be formed, as during the process said cap stretches the pre-heated blank by engaging with its base. The flowable medium outlet is fitted to the cap-shaped stretching die tip, preferably in the end region of the steel tube, where the stretching die tip is connected to the steel tube by means of a
25 screw or another fastening means. As far above this as possible on the stretching die tip, the flowable medium outlet is located. It has a hole structure. This means that at least one hole is arranged in the external wall of the tube such that the gases or other flowable media flowing through the internal channel of the hollow stretching die can exit from the steel tube through this hole or respectively through a suitable number
30 of holes. It is also possible for the flowable medium outlet to have a different exit arrangement with regularly or irregularly distributed holes. A hole structure can also be understood as a porous body of sintered metal, ceramics or the like which can

then act at the same time as non-return protection.

A preferred embodiment of the invention uses a hollow stretching die with a non-return valve which is also arranged in the area of the stretching die tip, however at a certain distance from it which is used on the one hand for receiving the flowable medium outlet, and on the other hand for the ignition means. The non-return valve in this embodiment has a valve body which can be moved with respect to a sealing seat inside the steel tube such that in this way the non-return valve is closed. If such a stretching die is arranged with strongly vertical components, preferably completely vertically, in the device according to the invention, the valve body exerts, by means of its weight, a kind of spring tensioning downwards against the sealing seat, so without a flowable medium flowing out of the internal channel, because of its weight the valve body always falls down onto the sealing seat and thereby closes the non-return valve. Obviously, the closing of the non-return valve can also be obtained in some way by building in a spring, which is necessary in particular when there is a non-vertical arrangement of the stretching die. Ignition takes place in any case in the device-side interior space, that is to say in the upper remaining space in the steel tube adjacent to the flowable medium outlet and outside the stretching die in the volume of the container, so the gas pressure increased by the explosion additionally presses the valve body against the sealing seat and closes the non-return valve.

The valve body can preferably carry turbulence-producing means. In this way a better turbulence of the flowable media mixture is obtained when it leaves the stretching die. For example, the moveable valve body can be provided with flowable medium guides running in a spiral shape on its external surface. Alternatively, outlet holes can be bored diagonally in the stretching die in order to give the exiting flowable medium a tangential speed component.

In the steel tube of the hollow stretching die, in other embodiments or alternatively in addition to the measures in the context of the embodiments described hereinabove, means are provided for good mixing of the flowable media. Thus, Christmas-tree-shaped components provided with lateral paddles can be provided in

The cap-shaped stretching die tip can be manufactured from different materials, wherein it can be made of solid plastics, of a plastics-coated steel cap, or of ceramics. A device has also already been operated and evaluated in which the stretching die tip is composed of steel. The reason for using steel instead of plastics, and for testing it, is to avoid excessive heating, and therefore affecting of the external surface of the stretching die in continuous operation.

25 Furthermore, a preferred embodiment of the invention is characterised in that the receiving portion is widened at the end facing the distributor module to form a service space in which, preferably, a centring is placed. The respective container to be manufactured has, in the case of a PET bottle, on one long end the infilling and
30 respectively pouring aperture in the form of a band with an external thread. In the case of the known device, the receiving portion grips around this open end of the container. Also according to the invention, the container to be manufactured is

It is further advantageous according to the invention when in the preferably stationary distributor module a hollow piston, driven axially moveable relative to said module, is provided, which has on its external end opposite the receiving portion an annular opposing sealing surface fitting the receiving portion. The distributor module can be also constructed in one piece, and connected in a sealing manner with a correspondingly moved receiving portion such that this connection between the receiving portion and distributor module can be terminated in a controlled manner. The termination is, however, done by means of the existing measures particularly advantageously with the hollow piston. In order to connect the distributor module to the receiving portion, and respectively to disconnect it, neither the distributor module nor the receiving portion needs to be moved axially – approximately in the direction of the hollow stretching die – as the hollow piston is driven axially moveably, preferably pneumatically. On its external end, the hollow

piston carries an opposing sealing surface fitting the receiving portion, which surface comes into sealing engagement with the sealing surface of the receiving portion when the receiving portion is connected to the distributor module. After the blowing and sterilising process, the movement of the hollow piston is reversed, so the sealing surface is disengaged from the opposing sealing surface, and then the receiving portion can be displaced in the manner described hereinabove perpendicularly to the direction of its longitudinal axis. This displacement transportation takes place each time following a blowing-sterilising procedure in the step-wise operating manufacturing process. According to the invention, in the distributor module, for guiding the stretching die, a sealing passage can be fitted in alignment with the hollow piston. With this, the movement of the stretching die in the axial direction through the distributor module, the hollow piston hereof, the receiving portion connected thereafter, and into the container, and respectively out of these parts, takes place whether the device-side interior space remains closed off in a gas-tight manner.

According to the paths of the flowable medium through the stretching die, past it or both of these, it can be advantageous when according to the invention at least one supply and connected to the metering device, and a drainage line, is connected to the distributor module. The drainage line serves to remove the reaction products, for example of the combustion gases, and optionally flowable residues.

The supply line is connected to the metering unit, which will be described hereinafter in more detail with reference to a preferred embodiment. There can be supplied, for example, for oxyhydrogen gas, hydrogen through one supply line and a mixture of oxygen and an inert gas through another supply line. With this it is advantageous when a flowable rinsing agent is forced from a further supply line to drive the reaction products out of the drainage line.

It should be noted that pressure sensors and temperature measuring devices could be arranged at different places in the device, preferably in the area of the distributor module, but also in the hollow stretching die.

It is also clear, that the ignition means can work on different physical principles. The ignition of the mixture of media takes place electrically in the most simple case by means of a spark discharge, made for example by a spark plug which can be fitted
5 on the stretching die or on the distributor; or by means of static discharge. Other ignition methods are conceivable, for example by beaming electromagnetic energy, in the form of a laser, high frequency or microwave pulse, or with the aid of a catalytic procedure.

10 Another advantageous embodiment of a metering unit provides the mixing of different flowable media directly in front of the stretching die, with directly following introduction into the blank. Particularly from the safety aspect, this represents a good compromise between the manufacturing of the mixture in a separate, explosion protected pressurised container and the metering unit described
15 hereinabove, in which by means of metering cylinders individual flowable media and/or mixtures of flowable media are supplied to the device-side interior space.

A practical embodiment is further characterised according to the invention in that in each of the supply and drainage lines connected to the distributor module there is
20 connected a non-return valve, and the ignition means is housed in the distributor module. The stretching die is then surrounded by the space in the distributor module, the space between the stretching die and hollow piston and that between the stretching die and receiving portion with a gap. This gap means an annular space which can be seen as a channel for flowable media and can be set out accordingly.
25 When set out larger, larger quantities of flowable media can be pumped into the container, and vice-versa. The explosion triggered by the ignition means in the distributor module then propagates itself very rapidly into the entire space filled with flowable medium. This space is limited by the non-return valves on the lines to the distributor module.

30

In an advantageous further configuration of the invention the hollow piston has on its end facing the receiving portion an annular sealing seat, and the stretching die

Figure 10 the same embodiment as in Figure 9, but with forming by explosion,
 Figure 11 a similar illustration of the device as in Figures 7 and 10, wherein a
 different type of stretching die is used, and
 Figure 12 enlarged, in cross-section, the receiving portion with the centring fitted
 5 above, by means of which the container to be manufactured is
 supported.

Figure 1 shows cut-away at the top right a container 1 manufactured by the stretch-
 blowing process made from plastics, for example, PET. While the completed
 10 container formed and removed from the tool is labelled 1, the container partly pre-
 formed by stretching and blowing is labelled 1' in the following drawings. The
 container 1 is manufactured from a blank labelled 2. Only the parts of the entire
 manufacturing unit which are important for the invention are shown, while parts of
 the tool known per se are omitted, thus, for example, the mould, the interior space of
 15 which corresponds to the finished container 1. The retainers and rails for
 transporting the workpieces according to the arrow 3 into the processing station and
 out of it are also omitted in the drawing. The receiving portion 4 is shown, however,
 which is widened at the upper end to form a service space 5, in which a centring 6 is
 fitted.

20

The container 1 to be manufactured is in this case shown as a PET bottle, which is
 arranged with its open end 7 upside down, facing downwards, and supported in the
 centring 7 and retained in a sealing manner in the receiving portion 4.

25 On the receiving portion 4 lines are provided axially, later described in more detail
 according to the embodiment, which can be connected to the receiving portion 4 and
 are removable from it such that the receiving portion is freely moveable with respect
 to the lines and the tool parts carrying them. These lines are in turn connected to a
 metering unit described in more detail in Figures 3a and 3b. In Figure 1, the lines 9
 30 and 10 are shown, the connection of which to the metering unit is shown in Figure
 3b. It is clear that depending on the place selected for producing the mixture – the
 metering unit, distributor module or blank – the distributor module can include

several supply lines 10, 10' instead of a single supply line 10. A pressure sensor 8 in the distributor module can be used for process control. The second supply line 10'a and third supply line 10'b (the further supply lines 10') are behind the pressure sensor 8 in Figure 3b.

5

For blowing and stretching the blank in the blown intermediate stage or respectively the intermediate forming stage (for example, in Figure 12) in a manner known per se, a stretching die generally labelled 11 is used, which is guided axially moveably through the receiving portion 4. Additionally according to the embodiment of the device, in one place an ignition means 12 is arranged for igniting an explosive gas mixture inside the container 1'. Heating and cooling devices, including the cooling means for the stretching die 11 are omitted for simplification and increasing the clarity of the drawings.

10

15 In the Figures of the embodiments shown here, many parts of the device, for example also the stretching die 11, extend in a vertical direction from below to above or vice-versa, wherein the construction and functioning of the device are simplified when the container to be manufactured is arranged above, the receiving portion 4 in between, and the stationary tool parts below. In the direction of the longitudinal central axis 13 shown in broken lines in Figure 4, the stretching die 11 also extends in the vertical with which the longitudinal central axis 13 should be thought of as coinciding. This longitudinal central axis also runs centrally through the receiving portion 4 and the blank 2 or respectively the future intermediately formed container 1' and the completed container 1. When the respective receiving portion 4 is moveable in the direction at right-angles to the longitudinal central axis 13, to transport the blanks 2 or respectively the containers 1, this transport direction is in the horizontal direction according to the arrow 3, while the longitudinal central axis is vertical.

20

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30 The receiving portion 4 can be brought into engagement by its end facing the container 1 or respectively the blank 2, which is always fitted above, in a flowable medium-tight manner with a distributor module 14. This distributor module 14 is

stationary and has a continuous vertical bore 15. At the bottom of this there is located a sealing passage 16 through which the stretching die is moveably guided concentrically and in a sealing manner from the outside into the distributor module 15 and oscillating upwards and downwards. At a small distance above the sealing
5 passage 16 in the inside of the distributor module 14, preferably at a distance of between 2 and 20 mm, there is located a hollow piston 17 which is movably driven relative to the stationary distributor module 14 axially in the bore 15 described, and thus parallel to the longitudinal central axis 13. At a distance from the internal walls of the hollow piston 17, the stretching die 11 moveable with respect to the parts
10 described runs, which can penetrate axially in alignment with the receiving portion into said receiving portion, and also into the blank 2 or respectively the container 1 held by it.

The hollow piston 17 has on its upper, namely its outer, end 18 which faces the
15 receiving portion 4, an annular opposing sealing surface 18 fitting said receiving portion. The hollow receiving portion 4 has on its end (below) facing the container 1 or respectively the blank 2, an annular sealing surface 19. This matches the opposing sealing surface 18 of the hollow piston 17 in such a manner that when the hollow piston 17 moves out of the position shown in Figure 1 upwards towards the
20 receiving portion 4, the opposing sealing surface 18 goes into the sealing surface 19, and ensures a suitable, flowable medium-tight connection. In other words, by means of the sealing surface 19 at the bottom on the receiving portion 4 and the opposing sealing surface 18 above on the hollow piston 17, the receiving portion 4 can be brought into flowable medium-tight engagement with the distributor module 14. By
25 means of the hollow space formed by the hollow receiving portion 4 and the hollow piston 17, the stretching die 11 is introduced axially such that the longitudinal central axis is common to all the parts of the tool.

Already in Figure 1, and particularly clearly in Figures 4 and 5, a hole 20 is shown in
30 the stretching die 11, which is one of the connectors for flowable media, which are connected via the stationary distributor module 14. In one embodiment, a connector for flowable media is the access 21 to the stretching die 11 which is then configured

hollow; or with another embodiment, connectors for flowable media are labelled 9 or 10 on the distributor module. On each connector for flowable media, non-return valves 23 are fitted for closing off and sealing the device-side interior space 22. According to the embodiment, these can have widely differing configurations, as
 5 will be explained in part hereinafter. The device-side interior space 22 is the space in the tool and in the blank 2 or respectively the container 1, in which the explosion of the gas mixture takes place.

The actual process with the ignition of the explosive gas mixture, in the embodiment
 10 selected here, a gas mixture, is well explained with reference to Figure 2. Over the time t (in ms) the pressure (in bar) is applied in the device-side interior space 22. The dashed line shows the conventional process. At $t = 0$, a mixture of hydrogen, oxygen and inert gas is blown in through the connectors for flowable media 9, 10, 21 provided for the purpose, as shown approximately in Figures 6 and 9, while the
 15 stretching die 11 is pushed out of the distributor module 14 through the receiving portion 4 upwards through into the blank such that it is stretched into the intermediate form of the intermediate container 1' shown rounded. Clearly, the blank 2 is previously heated to preferably 120°C. Between the times t_1 and t_2 , the internal pressure is kept in the range of approximately 5 – 10 bar (stretching
 20 pressure), so that the hot blank 2 is stretched and thereby its diameter also increases. Formerly, at time t_2 , the internal pressure of the non-explosive gases was increased to a good 30 bar, and kept until time t_5 , whereby the blank 2 or respectively the intermediately formed container 1' was completely pressed against the tool mould, and thereby obtaining the final form of the container 1 to be manufactured, for
 25 example, the PET bottle. Ventilation then took place, the mould was meanwhile cooled, and the finished container removed from the form after time t_7 .

With the new process with the explosive mixture, for example, oxyhydrogen gas, the stretching and blowing takes place by means of the increased internal pressure up
 30 until time t_2 in the same way. Thereafter, however, the oxyhydrogen gas is ignited, whereby the pressure is briefly increased up to time t_3 to over 35 bar, and up to time t_4 goes down again to below 20 bar. An inert gas or another gas physically involved

with the mixture but not involved in the chemical reaction is introduced at pressure between times t_4 and t_6 into the interior space 22 and respectively kept there under pressure in order to hold the internal walls of the container 1 just manufactured against the internal wall of the mould, and to ensure cooling and hardening of the plastics material. After time t_4 depressurisation takes place and at t_7 , the container 1
5 can be removed from the tool.

A first embodiment of the metering unit is described with reference to Figures 3a and 3b. The distributor module shown in Figure 3b on the right is, in the case of the
10 embodiment shown here, supplied with a gas mixture via the supply line 10'a or the supply line 10'b. This can be done via the respective non-return valve 23 and the respective valve labelled 24 via the line 8' or the line 8'' from a mixing and pressurising cylinder 25 (Figure 3a). The latter is driven by the motor M and can mix various gases according to the setting of the valves 24, and supply the further
15 supply line 10' by means of the line 10'a and/or 10'b. With the preferred embodiment taken here, the gas container 26 holds a mixture of argon and oxygen (alternatively with another embodiment, for example, also air). The gas container 27 contains argon. By means of the mixing and pressurising cylinder 25, which can have, for example, a volume of 2 litres, oxygen can be mixed as desired with a more
20 or less large amount of argon, and then supplied to the supply line 8.

In order for oxyhydrogen gas to be an explosive gas mixture, according to Figures 3a and 3b oxygen is stored in the gas container 28. This is pre-compressed by means of a pressurising cylinder 29 with a volume of, for example 0.8 litres, to a first pressure
25 of 2.5 bar, and to a stretching pressure of 10 bar. For safety reasons, further non-return valves 23 are connected in front of the connector for flowable media 21 in the stretching die 11.

Alternatively, in order to avoid the storage of large quantities of oxygen, and thereby
30 to further increase the safety of the installation, the oxygen required can, for example also be continuously produced in the respective small amounts required in a parallel manner in an electrolysing unit.

By means of the supply line 9 connected to the metering unit, a flushing gas is introduced through the line 30 in the direction of the arrow 31 shown at the bottom right in Figure 3b, again by means of a non-return valve 23, into the distributor module 14. This flushing gas is, with this embodiment, compressed air, and acts to force out water and gas residues from the system after the explosion.

In Figure 3b at the bottom right the zig-zag arrow in the circle is the symbol for high voltage generation 32. The high voltage then leads into the ignition means 12 lying further up, to ignite the explosion.

Figures 3c and 3d describe a second other embodiment of a metering unit. The metering unit according to Figures 3c and 3d is constructed in a very similar manner to that according to Figures 3a and 3b, so like parts have like terms and reference labels. The pressure tank 25a shown in Figure 3c is different, from which tank only one supply line 8' leads via the valve 24 to the non-return valve 23 and from there as a supply line 10'a to the distributor 14.

The first embodiment according to Figures 3a and 3b can be modified to obtain the embodiment according to Figures 3c and 3d such that when blank pressing takes place at under 10 bar, the mixing and pressurising cylinder 25 with its supply and drainage lines is replaced by the pressure tank 25a described. In said tank the gases are mixed, for example, the gases coming from the gas containers 26 (argon and oxygen) and 27 (argon) and fed to the pressure tank 25a. From this pressure tank 25a, there is then only one supply line 8' leading to the distributor module 14, as is shown in Figure 3d. Instead of the mixing and pressurising cylinder 25 of Figure 3a, in the second embodiment of Figure 3c, oxygen can be mixed as desired with a more or less large amount of argon in the pressure cylinder 25a, and then supplied to the distributor via the supply line 10'a.

30

In Figures 4 and 5 the upper or respectively the container-side end of the hollow configured stretching die 11. Right at the top there is located a stretching die tip 33

made from plastics, which in other embodiments can also be composed of steel or ceramics. In the present embodiment, plastics is selected so that the tip used for the stretching of the container 1' does not heat up excessively. By means of the continuing and discontinuously operating ignition means 12, the stretching die 11 heats up, which stretching die is, in its substantial portion below the cap-shaped stretching die tip 33, a steel tube 34. The stretching die tip 33 is screwed via the holder 35 to the steel tube 34. At a small distance below the holder 35, holes 20 are located in the steel tube 34, which serve as outlets for flowable media in a hole structure. The flowable medium has to be able to leave the elongated device-side interior space 22 from the hollow stretching die 11, through the holes 20. The device-side interior space 22 is, in the case of this embodiment, an elongated internal channel which extends parallel to the longitudinal central axis 13, from the non-return valve 23 to the height of the holes 20.

The ignition means 12 has, in the illustration according to Figures 4 and 5, a spark plug which is also parallel to the longitudinal central axis 13, and terminates upwardly in the area of the holes 20. The non-return valve 23 is connected below. The ignition device 12 is thus arranged above with respect to the non-return valve 23, that is to say on the side facing the holes 20. On the side of the non-return valve 23 opposite the holes 20, a cable 36 is connected which is fed from the non-return valve 23 parallel to the longitudinal central axis 13 downwards, as can be seen clearly in Figure 5. This cable 36 is electrically connected to a control unit which is not shown, in order to be able to ignite the explosion at any time desired.

The non-return valve 23 in the hollow stretching die 11 is provided with a moveable valve body 37. This valve body 37 can be set up to be flowable medium-tight against a stationary sealing seat 38 fitted internally in the steel tube 34. It is evident from Figures 4 and 5 that with ignition of a gas mixture in the device-side interior space 22 (above the internal channel 39 described in the hollow stretching die 11) the over-pressure presses the valve body 37 vertically upwards against the sealing seat 38, and thereby triggers the functioning of the non-return valve 23.

With the embodiments shown here, the valve body 37 can carry turbulence producing means, for example, turbulence producing paddles like the branches of a Christmas tree, or alternatively gas outlets arranged in a spiral shape. In this way the turbulence of the gas mixture when leaving the stretching die 11 can be further improved.

While in Figure 1, the distributor is shown separated from the receiving portion, so that the receiving portion 4 can be moved perpendicularly to the longitudinal central axis 13, namely in the direction of the arrow 3 (horizontally) from one station (left) to the next (centre or right) relative to the distributor 14, in Figure 6 the connection of the distributor 14 and respectively its hollow piston 17 with the receiving portion 4 is shown. Figure 6 shows a specific operating condition. In order to produce this gas-tight connection between the receiving portion 4 and the distributor 14 and respectively its hollow piston 17, the hollow piston 17 is moveable up and down vertically in the direction of the longitudinal central axis. The receiving portion 4 is not moveable in this direction, and the distributor 14 is in any case stationary. If compressed air is fed via the lower pneumatic connector 40 into the cylinder within the continuous vertical bore 15, the hollow piston 17 then moves upwards into the position shown in Figure 6. (The other way around, compressed air can be fed into the upper pneumatic connector 40 in order to move the hollow piston 17 back down again into the position shown in Figure 1).

In order to obtain the operating state shown in Figure 6, a mixture of argon as the inert gas, plus oxygen from the gas container 26 is fed through the supply line 8 into the space around the stretching die 11, and forced into the space still present as a (heated) blank, as the fluid arrows 41 in Figure 6 show. During this blowing out, the stretching die 11 is also pressed vertically upwards against the base of the blank 2 such that the internal pressure plus the mechanical pressure of the stretching die 11 blow out the softened plastics material of the blank into the intermediate form of the container 1' according to Figure 6. The supply of oxygen gas helps to support this, which gas is supplied via the connector for flowable media 21 below in the stretching die 11, and is forced through the internal channel 39 (shown in Figures 4

and 5) upwards to the holes 20, where the oxygen flows according to the oxygen arrows 42 into the volume of the intermediate container 1'. The material of the blank 2 lies, in the form of the intermediate container 1', more or less on the internal surface, which is not shown, of the moulding tool, wherein with the aid of the gases (41, 42) and of the stretching die 11, blowing and stretching takes place.

Naturally, it is also possible to force the mixture of inert gas and oxygen in the direction of the further arrow 43 (gas mixture inlet) through the supply line 9 into the distributor module 14, so that it enters in the manner of the fluid arrows 41 in the same way as described hereinabove into the volume to be blown out. This constituted the pre-stretching and forming.

The next operating state can be well explained with reference to Figure 7. Here, forming takes place by means of explosion. Behind the holes 20 in the hollow stretching die 11, there is located the ignition means 12 which obtains the signal for ignition by means of its cable 36, when the pre-stretching and forming is finished and the intermediate shape of the container 1' is obtained. By means of the ignition which is indicated in Figure 7 at the top by the asymmetrical star 44 (ignition), water is formed from the gas mixture of oxygen and hydrogen by means of the oxyhydrogen gas explosion, according to the formula $2H_2 + O = 2H_2O$. According to Figure 2, in time t_2 to time t_3 a very high pressure of over 35 bar is briefly created. This gas pressure ensures the contact of the still warm plastics walls on the internal surface of the mould, so the shape of the finished container 1 occurs, as is shown in Figure 7. In this state, the stretching die 11 is located in its position pushed out upwardly. In this position, the holes 20 with the ignition means 12 located behind them, lie clearly in the centre in the volume of the container 1 to be formed. Not only does the pressure ensure good forming of the container 1, but also a brief increase in temperature occurs so that the interior space of the container 1 is sterilised at the same time.

30

In order that the configurations and dimensions can be better evaluated, the same illustrations in Figure 8 are shown in perspective and partly cut away. In order that

water occurring in the device-side interior space 22 due to the oxyhydrogen gas explosion can be ventilated and removed, the line 10 leading outwards diagonally downwards is provided, which line leads to the outlet 45 according to the arrow in Figure 3b. Additionally, the flushing gas from the line 30 via the supply line 9 for driving out water and other gas residues can act in a supporting manner.

It is obvious that to obtain lower operating costs it is advantageous not to simply blow off the argon not involved in the chemical reaction after forming of the container, but rather to clean and dry it in a recovery installation and use it again.

10

It can be imagined from Figure 8 that the hollow piston 17 is moved in the direction of the longitudinal central axis 13 vertically downwards after ventilation, so that the annular sealing surface 19 on the receiving portion below the opposing sealing surface 18 on the external end of the hollow piston 17 is lifted up such that the state according to Figure 1 is obtained again. Now, with the aid of the horizontal feed mechanism, which is not shown, the receiving portion 4 is moved with the newly formed container 1 in the direction of the arrow 3 horizontally out of the central position into the position shown in Figure 8 at the top right rear. At the same time the receiving portion 4 shown at the left front is brought with the blank 2 into the central position, so that the state shown in Figure 1 is obtained again.

20

Another embodiment is shown in Figure 9. Here, the stretching die 11 is not configured hollow, but instead solid. On its upper, external, free end, it is provided with a ball 46. For pre-stretching and forming in Figure 9, inert gas, oxygen and in this case also hydrogen is blown in a similar manner to Figure 6, from below from the open end 7 of the container 1' around the stretching die 11 within the hollow piston 17 and the receiving portion 4, vertically upwards from a supply line here labelled 10, and in accordance with the fluid arrows 41 into the hot blank 2 such that with the aid of the stretching die 11 with its ball 46 (located on the tip), the intermediate form of the container 1' is formed.

30

In the embodiment of Figure 9, the non-return valves 23 are active in closing off the

In the embodiment of Figure 11, on the other hand, the annular sealing seat 48 in the hollow piston 17, which tapers vertically upwards in the manner of a truncated cone, engages with a shoulder 49 on the solidly configured stretching die 11. This shoulder 49 is located far below the free upper end of the stretching die. The distance from the upper free end of the stretching die 11 is approximately the same as the length of the container 1 to be manufactured plus the length of the receiving portion 4, both measured in the direction of the longitudinal central axis 13. The stretching die 11 thus engages by means of its shoulder 49 with the annular sealing seat 48 in the hollow piston 17 according to Figure 11, when the thinner part of the stretching die 11 is pushed up above the shoulder 49 completely up into the container 1 to be manufactured. The shoulder 49 can then lie on the sealing seat 48 and closes off the device-side interior space 22 which constitutes the volume in the receiving portion 4 plus the volume in the container 1 to be manufactured from the outside. The annular space in the hollow cylinder 17 and in the distributor module 14 outside the lower, thicker part of the stretching die 11 with the larger diameter is not subjected to the high pressure and the high temperature when the oxyhydrogen gas is ignited. The advantage of the embodiment of Figure 11 compared to that of Figure 10 is in that the ignition by an ignition means not shown in Figure 11, which is arranged, for example, in the area of the receiving portion, can trigger the explosion while the stretching die 11 is still conducted into its pushed forward "stretching position". The time taken for withdrawing the stretching die 11 vertically downwards is thus saved.

In the two embodiments according to Figures 9 and 10 on the one hand and also according to Figure 11 on the other hand, the stretching die 11 is solid, that is to say is not configured hollow. In both embodiments the device-side interior space 22 can be closed off from the outside by means of the radially widened portion (ball 46 or shoulder 49), without a non-return valve having to be arranged in addition.

The further advantage of the embodiment according to Figures 9 and 10 is in that the diameter of the stretching die 11 compared to the stretching die with the hollow configuration can be very small, with the result that a larger free cross-section in the

form of the annular space around the stretching die 11 is available for the blowing in of fluid (gas mixtures). In this way time is gained, as the device-side interior space 22 can be filled more rapidly with the desired fluid. It is also advantageous that the stretching die 11 in the embodiment according to Figures 9 and 10 is no so hot, as
5 only a smaller part thereof is located in the explosion area.

Figure 12 clearly shows the external thread of the open end 7 of the container 1' which can later be closed after filling by means of a cap. It is often desired to keep the cap, and in particular its internal area, including the thread, sterile. It is then
10 advantageous when the external thread on the open end 7 of the container 1' is sterilised. This sterilising is done by brief heating during the explosion of the oxyhydrogen gas, wherein sterilising hot gas also acts in the service space 5 within the centring 6 upon the external thread on the open end 7 of the container 1'. With suitable size and construction of the service space, it is thus also possible to sterilise
15 the closure later used to close the container in the same operating process.

List of designations

	1	container
	1'	partly formed container or respectively intermediate blank
	2	blank
5	3	arrow
	4	receiving portion
	5	service space
	6	centring
	7	open end of the container
10	8	pressure sensor
	8', 8"	supply line
	9	supply line
	10, 10'	10a, 10'b
		supply lines
15	11	stretching die
	12	ignition means
	13	longitudinal central axis
	14	distributor module
	15	continuous vertical bore
20	16	sealing passage
	17	hollow piston
	18	opposing sealing surface
	19	annular sealing surface
	20	hole
25	21	connector for flowable media
	22	device-side interior space
	23	non-return valve
	24	valve
	25	mixing and pressurising cylinder
30	26	gas container
	27	gas container (argon)
	28	gas container (hydrogen)
	29	pressure cylinder
	30	flushing gas line
35	31	arrow
	32	high voltage generation
	33	stretching die tip
	34	steel tube
	35	holder
40	36	cable
	37	moveable valve body
	38	sealing seat
	39	internal channel
	40	pneumatic connector
45	41	fluid arrow
	42	H ₂ arrow
	43	arrow (gas mixture inlet)

- 44 star (ignition)
- 45 outlet
- 46 ball
- 47 sealing seat in the hollow piston
- 5 48 sealing seat in the hollow piston
- 49 shoulder

Claims

1. Device for manufacturing container (1, 1') from a plastics material which can be formed by stretch-blowing with a mould, the internal space of which corresponds to the finished container (1), which is held by its open end (7) by a receiving portion (4), wherein lines (9, 10) connected to a metering unit are provided on the receiving portion (4), a moveable stretching die (11) is guided axially through the receiving portion (4) and an ignition means (12) is arranged in order to ignite an explosive gas mixture inside the container (1'), and wherein heating and cooling means are provided, characterised in that the receiving portion (4), at its end opposite the container (1) can be engaged in a flowable medium-tight manner with a distributor module (14), through which the stretching die (11) is moveably passed axially extending the receiving portion (4), and on which at least one connector for flowable media (9, 10, 21) is fitted, in that the at least one connector for flowable media (9, 10, 21) can be closed off in order to seal the device-side interior space (22), and in that the ignition means (12) is fitted in the device-side interior space (22).
2. Device according to claim 1, characterised in that the receiving portion (4) is hollow and has on its end opposite the container (1) an annular sealing surface (19) through which the stretching die (11) is moveably passed axially extending the receiving portion (4).
3. Device according to claim 1 or 2 characterised in that the closing means for sealing off the device-side interior space (22) is a non-return valve (23).
4. Device according to one of claims 1 to 3, characterised in that the stretching die (11) is configured hollow, with at least one outlet aperture (20) arranged on a stretching die tip (33), at least one flowable medium inlet (21) and with at least one internal channel (39) connecting them (20, 21), and in that preferably a non-return valve (23) is fitted in the area of the outlet aperture

(20).

5. Device according to one of claims 1 to 4, characterised in that in the area of the outlet aperture (20), an ignition means (12) is fitted in the hollow stretching die (11) on the side of the non-return valve (23) facing the outlet aperture (20), and is preferably electrically connected via the cable (36) running in the hollow stretching die (11) to a control unit.
6. Device according to one of claims 1 to 5, characterised in that the hollow stretching die (11) driven moveably in the longitudinal direction is a steel tube (34) with a cap-shaped stretching die tip (33) on which the flowable medium outlet (20) is fitted in a hole structure, and in that the non-return valve (23) is provided with a valve body (37) moveable with respect to a sealing seat (38) fitted inside the steel tube (34), and preferably carrying turbulence producing means.
7. Device according to one of claims 1 to 6, characterised in that the receiving portion (4) is moveably driven perpendicular to its longitudinal central axis (13).
8. Device according to one of claims 1 to 7, characterised in that the receiving portion (4) is widened at the end opposite the distributor module (14) to form a service space (5) in which preferably a centring (6) is fitted.
9. Device according to one of claims 1 to 8, characterised in that in the preferably stationary distributor module (14) a hollow piston (17) arranged moveably axially with respect thereto is provided, which on its external end facing the receiving portion (4) is provided with an annular opposing sealing surface (18) fitting the receiving portion.
10. Device according to one of claims 1 to 9, characterised in that in the distributor module (14), for guiding the stretching die (11) a sealing passage

(16) is fitted in alignment with the hollow piston (17).

11. Device according to one of claims 1 to 10, characterised in that at least one supply line (10', 21) and one drainage line (10) connected to the metering unit are connected to the distributor module (14).

12. Device according to one of claims 1 to 11, characterised in that in each of the supply lines (9, 10', 21) and drainage lines (10) connected to the distributor module (14), a non-return valve (23) is connected, and the ignition means (12) is fitted in the distributor module (14).

13. Device according to one of claims 1 to 12, characterised in that the hollow piston (17) is provided on its end facing the receiving portion (4) with an annular sealing seat (47, 48), and the stretching die (11) carries on its end which is moveable into the container to be manufactured (1, 1') a radially widened portion (46) perpendicular to its longitudinal axis (13) for engaging with the sealing seat.

Abstract

Device for manufacturing plastics containers by means of stretch-blow forming

5

A device is described for manufacturing containers (1) from a plastics material which can be formed by stretch-blowing with a mould, the internal space of which corresponds to the finished container (1), which is held by its open end (7) by a receiving portion (4), wherein lines (9, 10) connected to a metering unit are provided on the receiving portion (4), a moveable stretching die (11) is guided axially through the receiving portion (4), and an ignition means is arranged for igniting an explosive gas mixture inside the container, and wherein heating and cooling means are provided.

15 In order to manufacture plastics containers with an improved appearance, for example, with largely clearly transparent walls, without a large additional expense being necessary, according to the invention it is provided that the receiving portion (4), at its end opposite the container (1) can be engaged in a flowable medium-tight manner with a distributor module (14), through which the stretching die (11) is
20 moveably passed axially extending the receiving portion (4), and on which at least one connector for flowable media (8, 10, 21) is fitted, in that the at least one connector for flowable media (9, 10, 21) can be closed off in order to seal the device-side interior space (22), and in that the ignition means (12) is fitted in the device-side interior space (22).

25

Figure 1

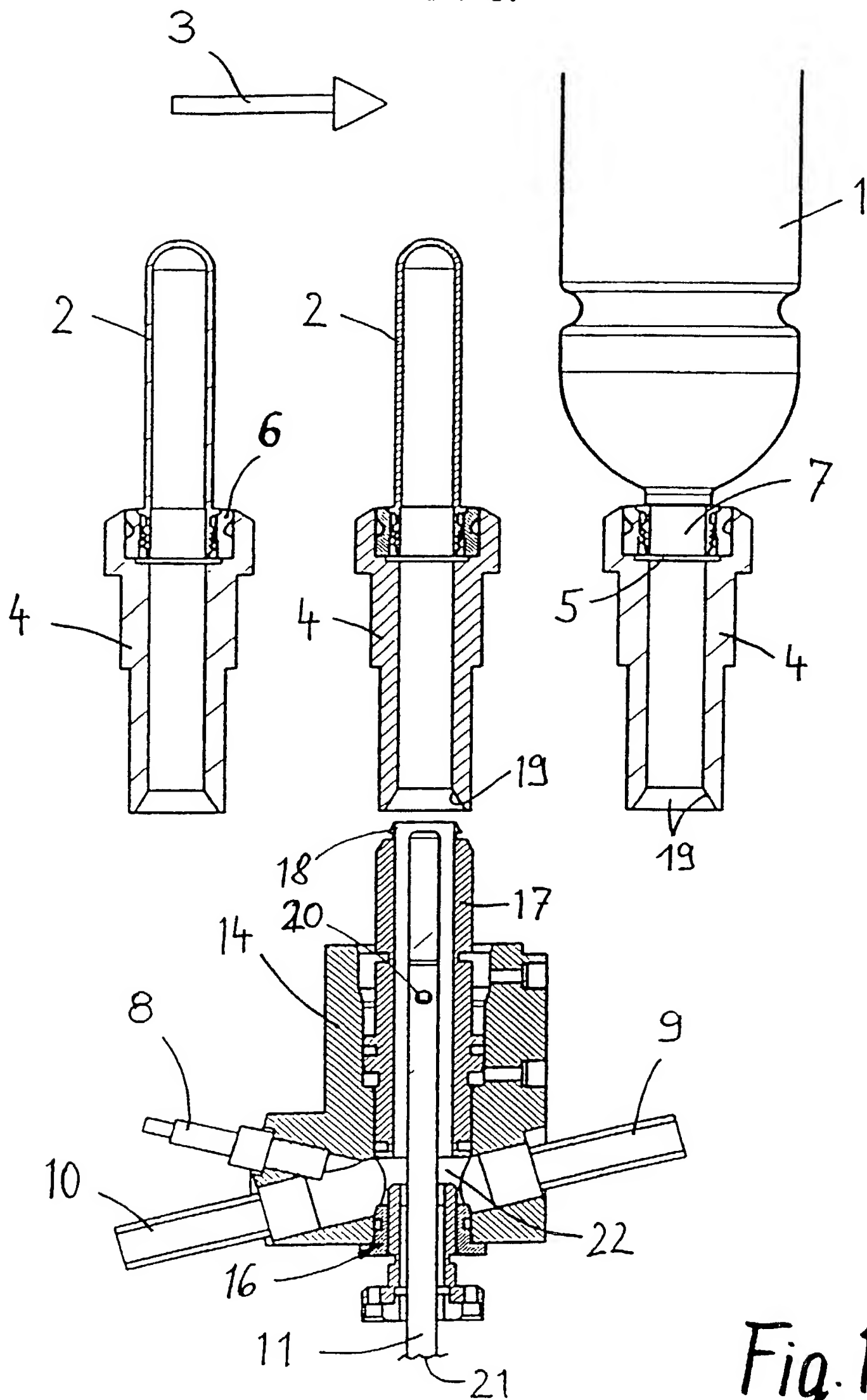


Fig. 1

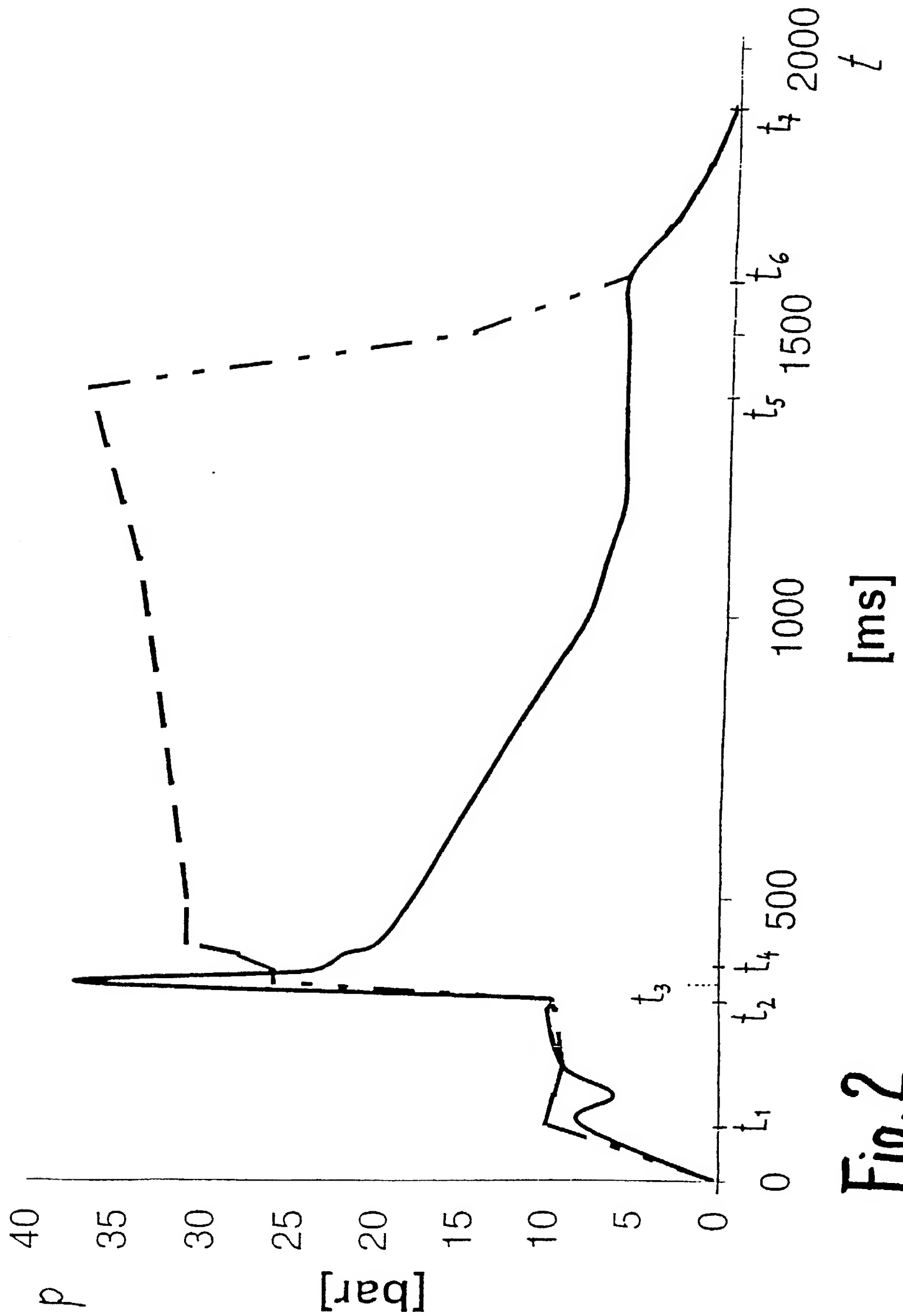


Fig. 2

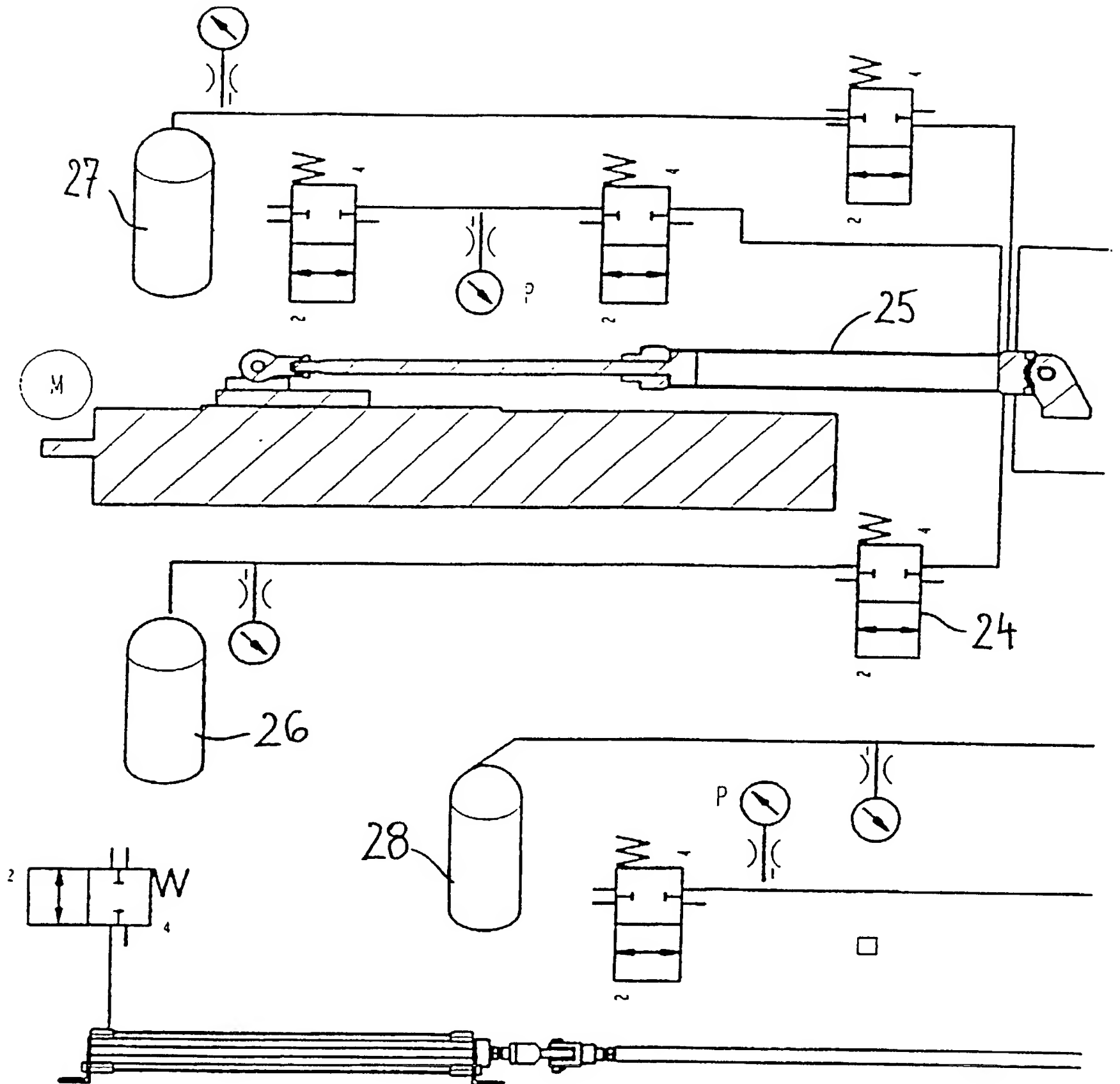
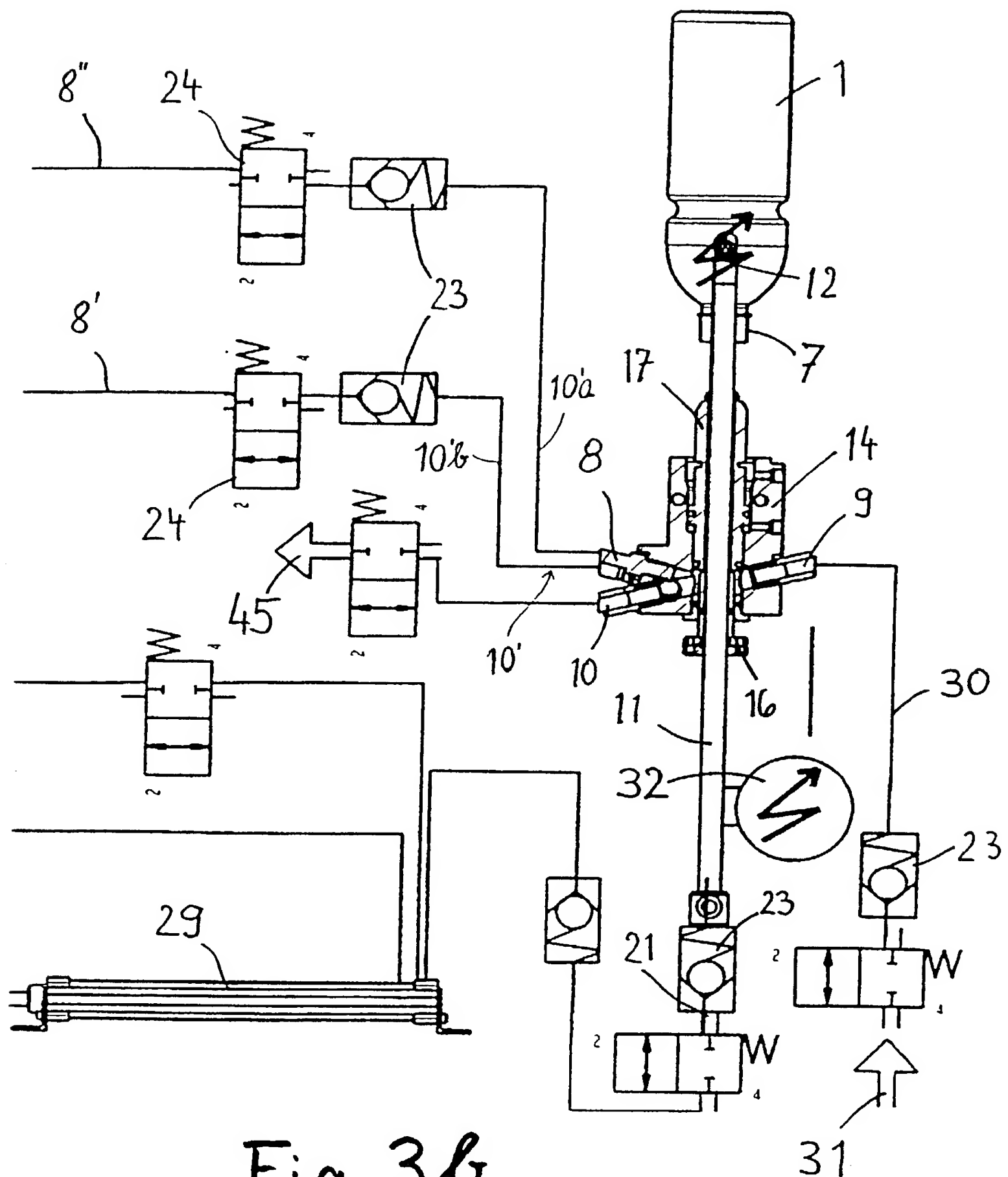


Fig. 3a



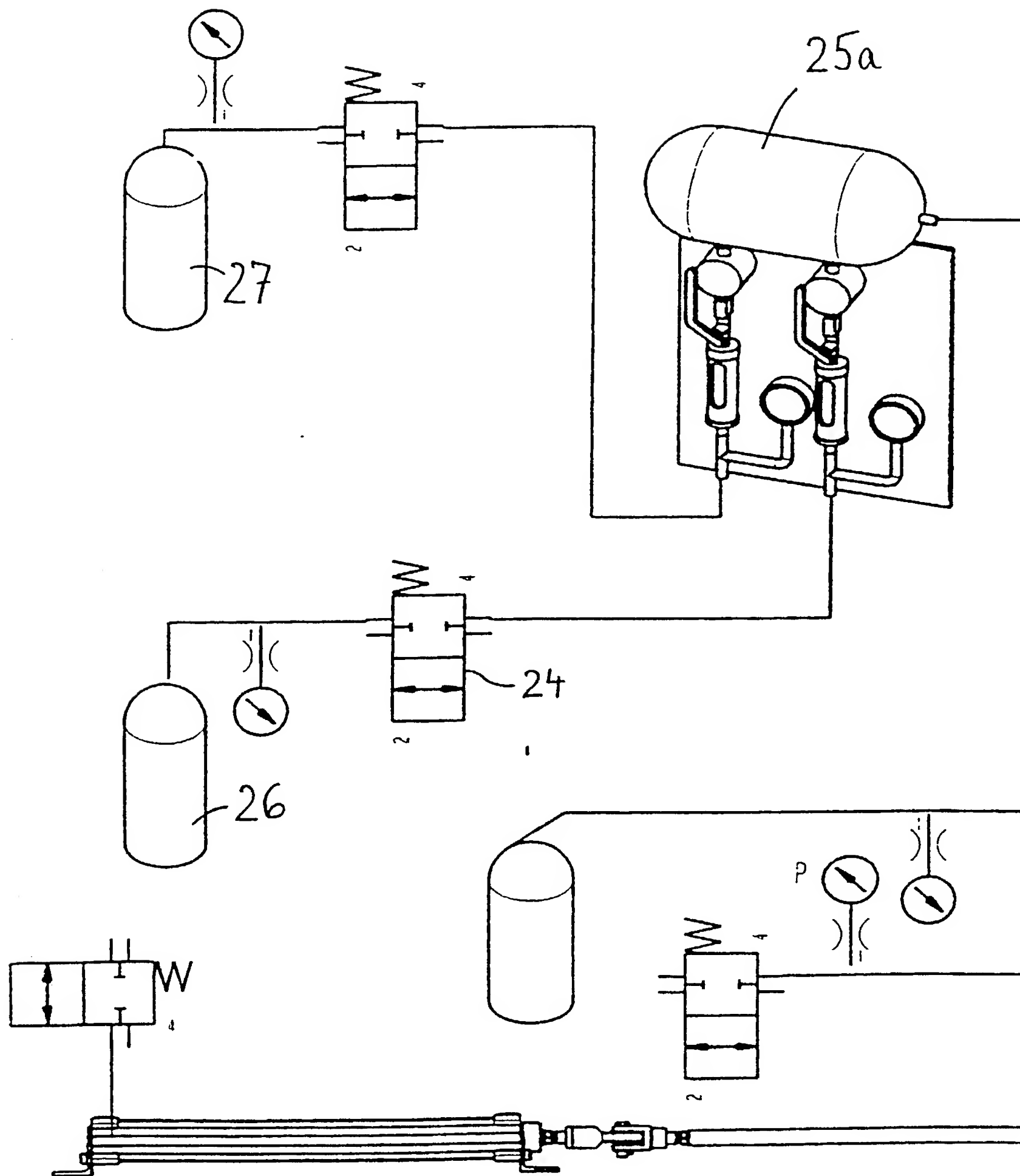
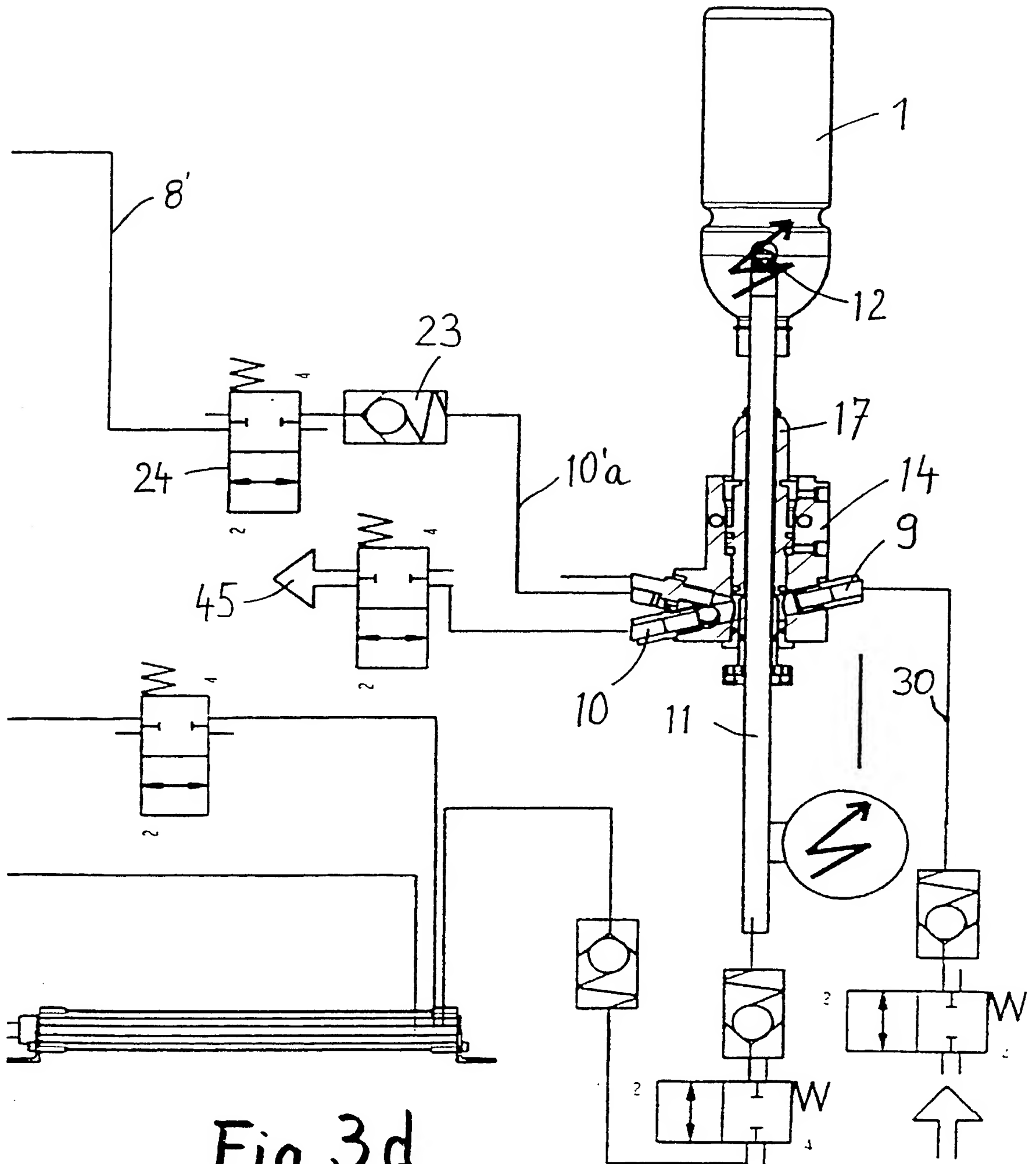


Fig. 3c



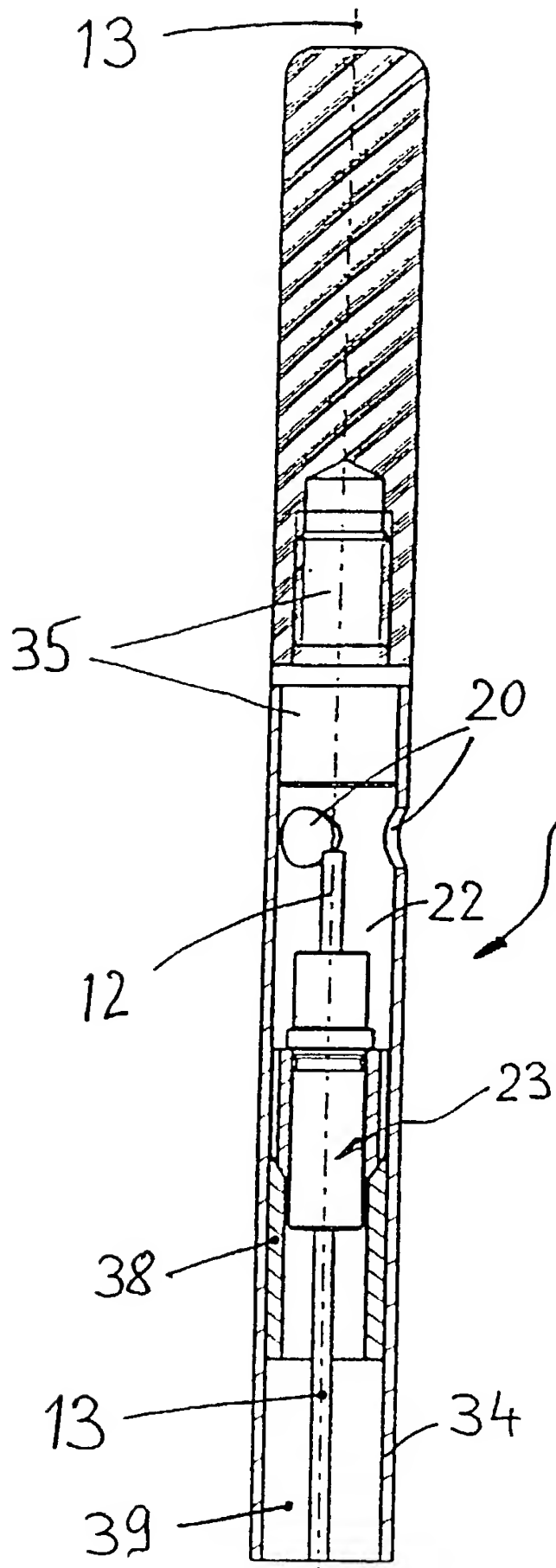


Fig. 4

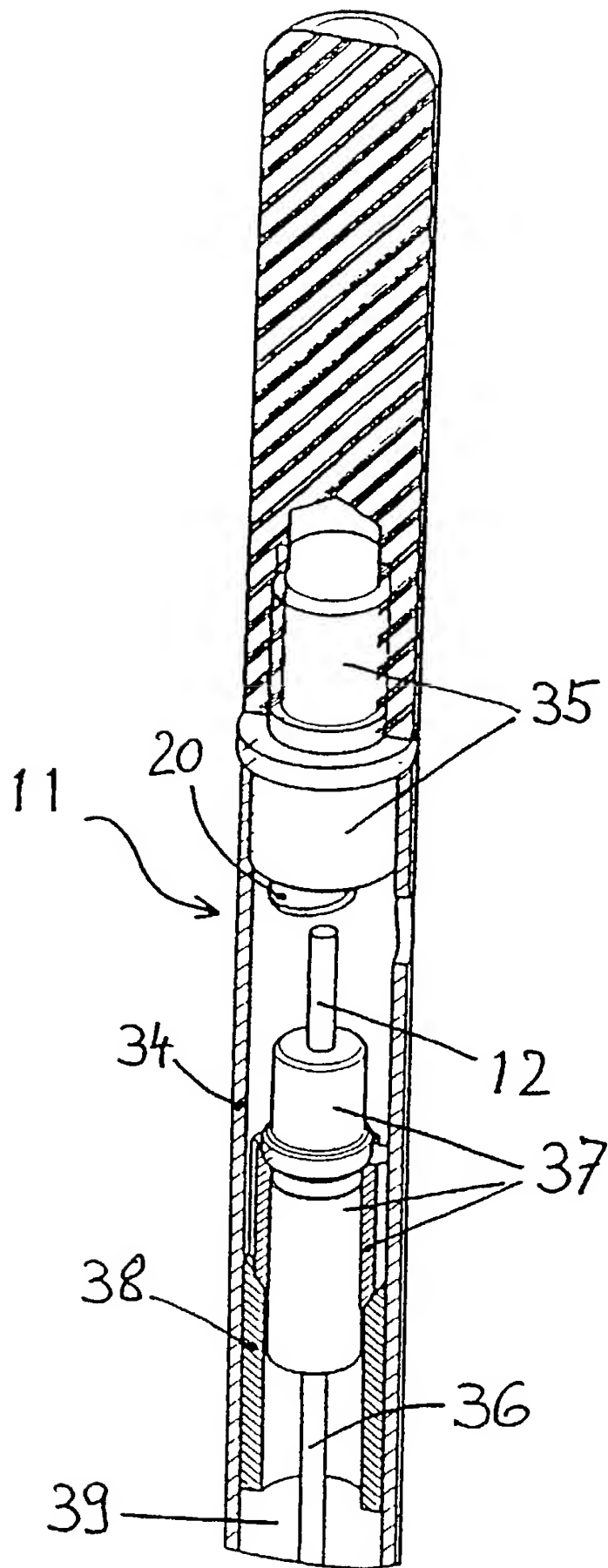


Fig. 5

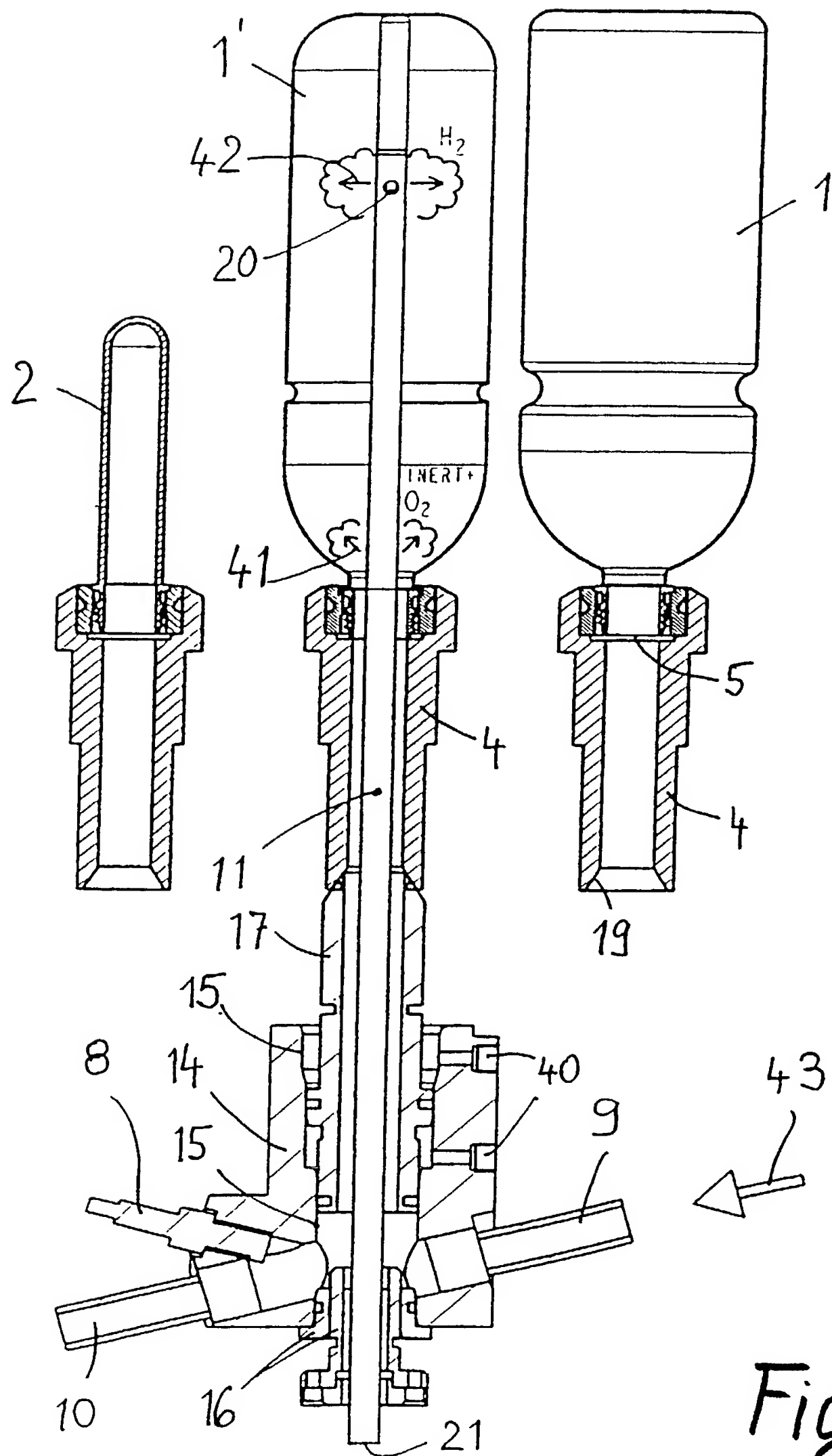


Fig. 6

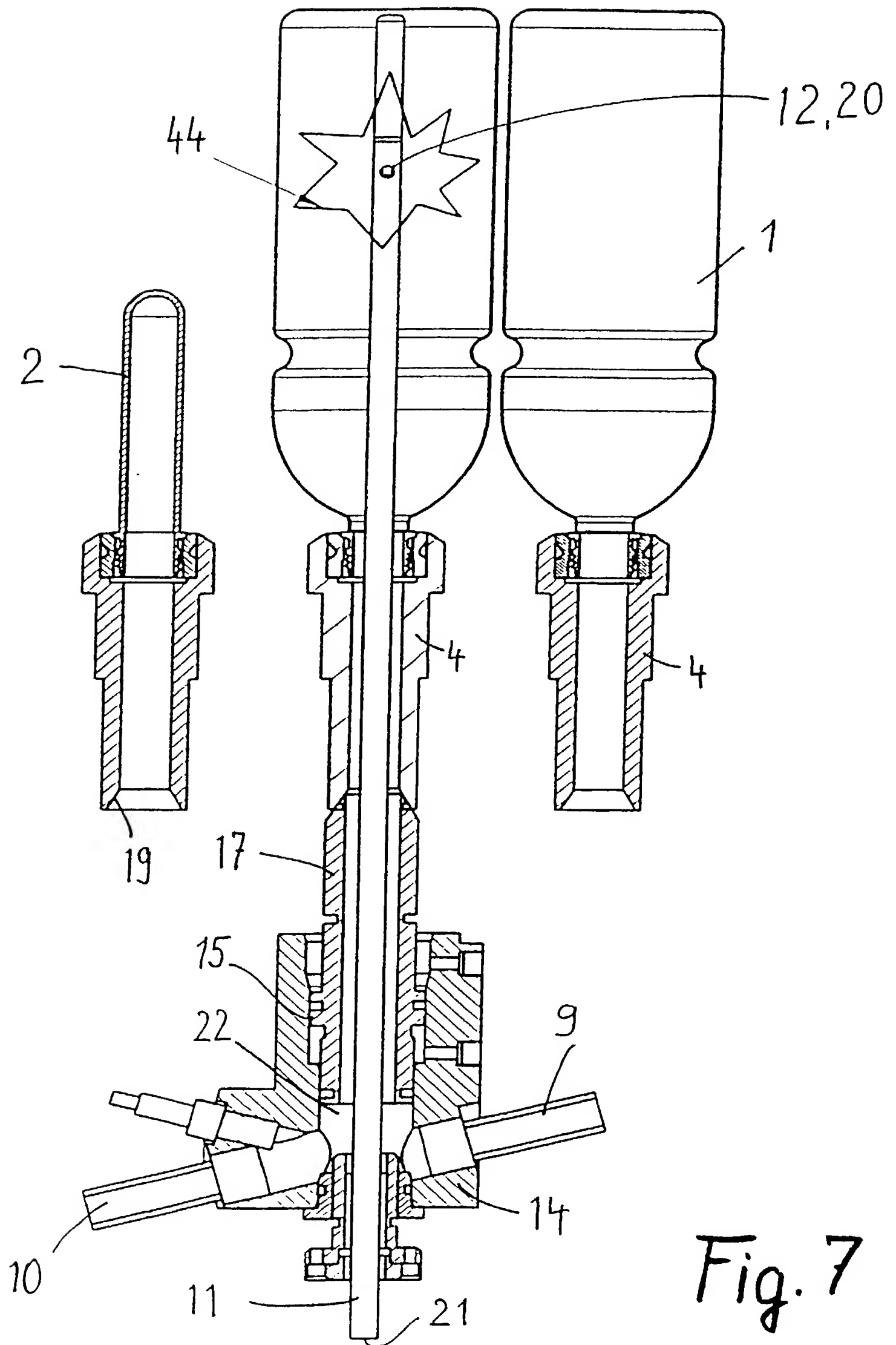


Fig. 7

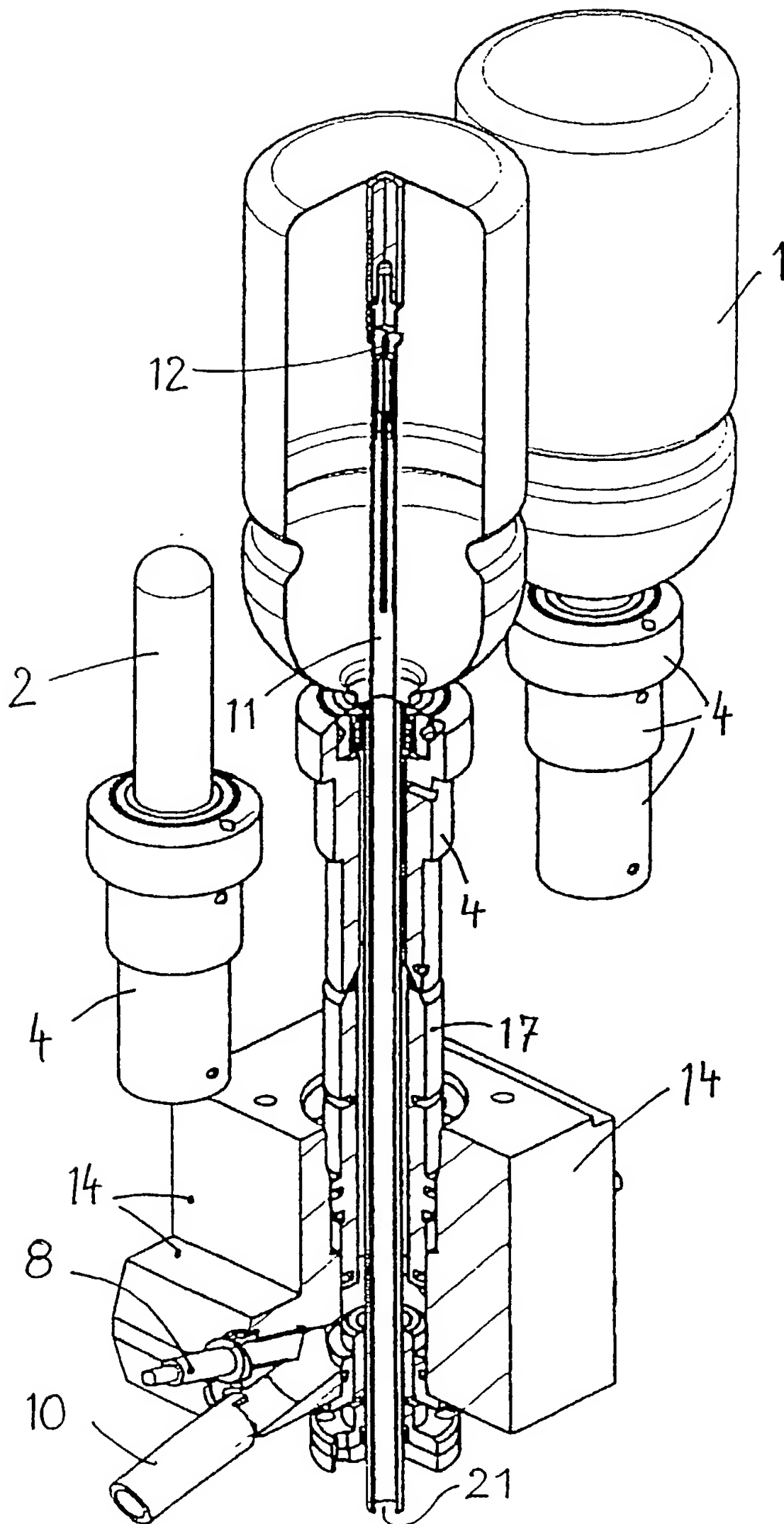


Fig. 8

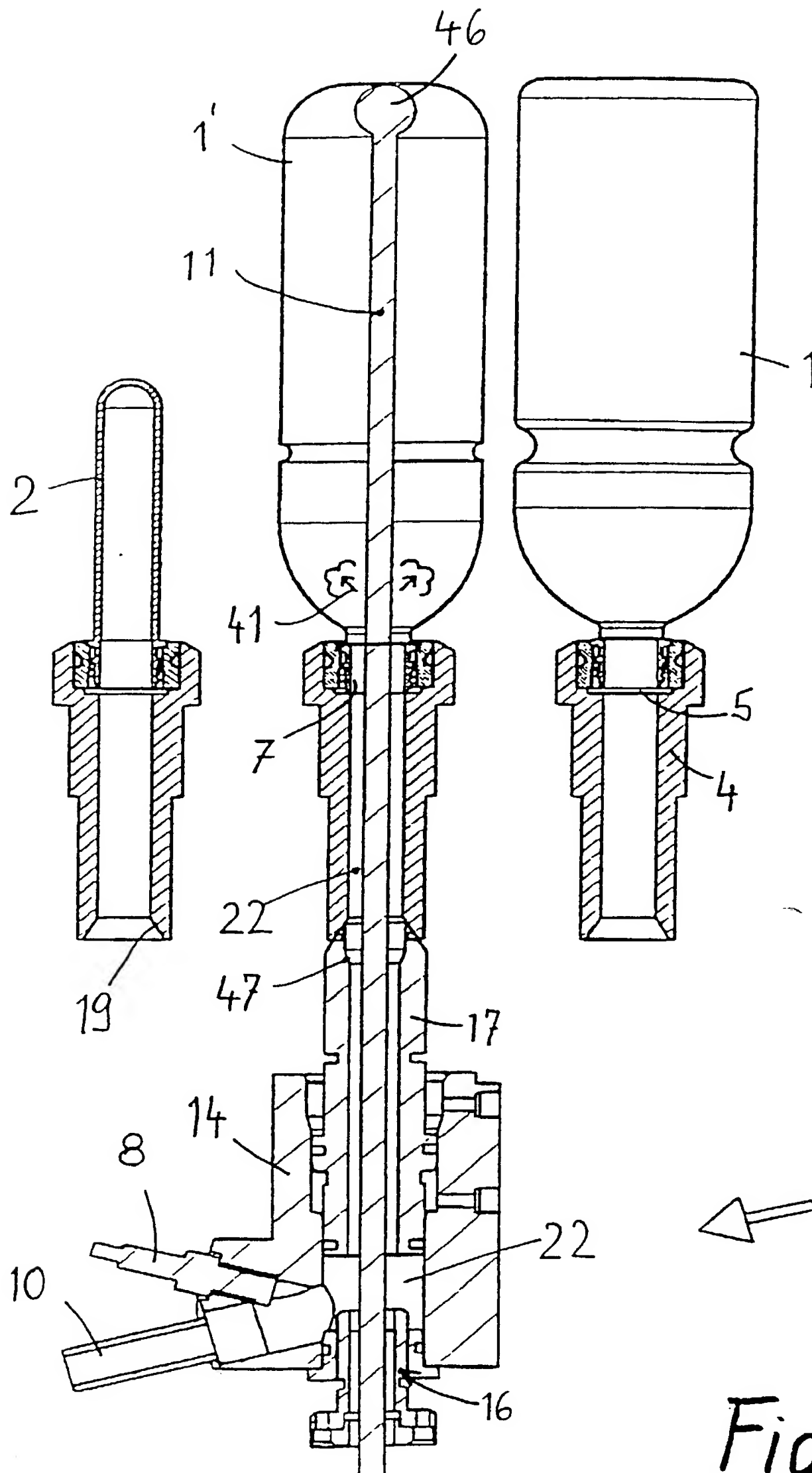


Fig. 9

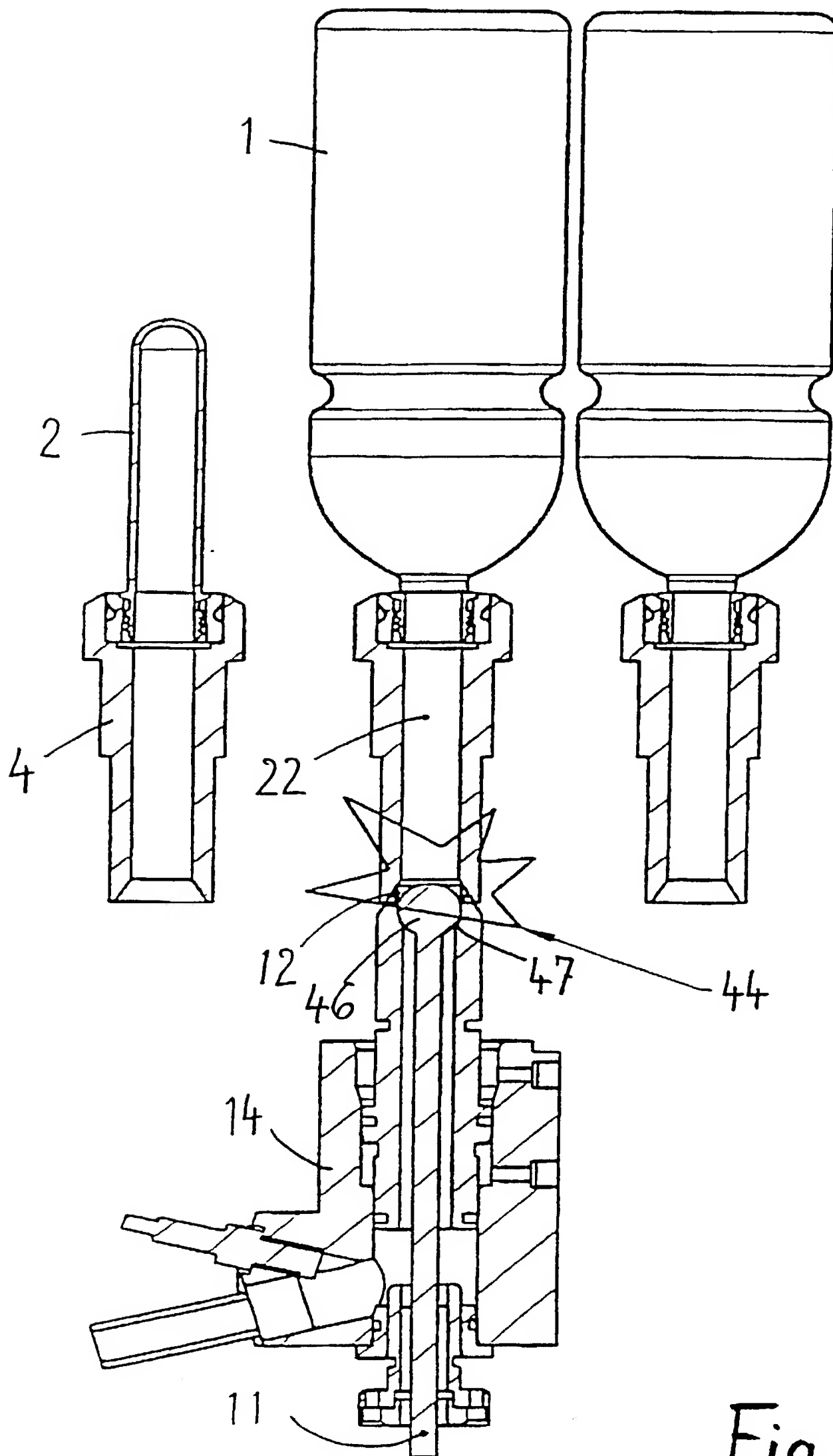
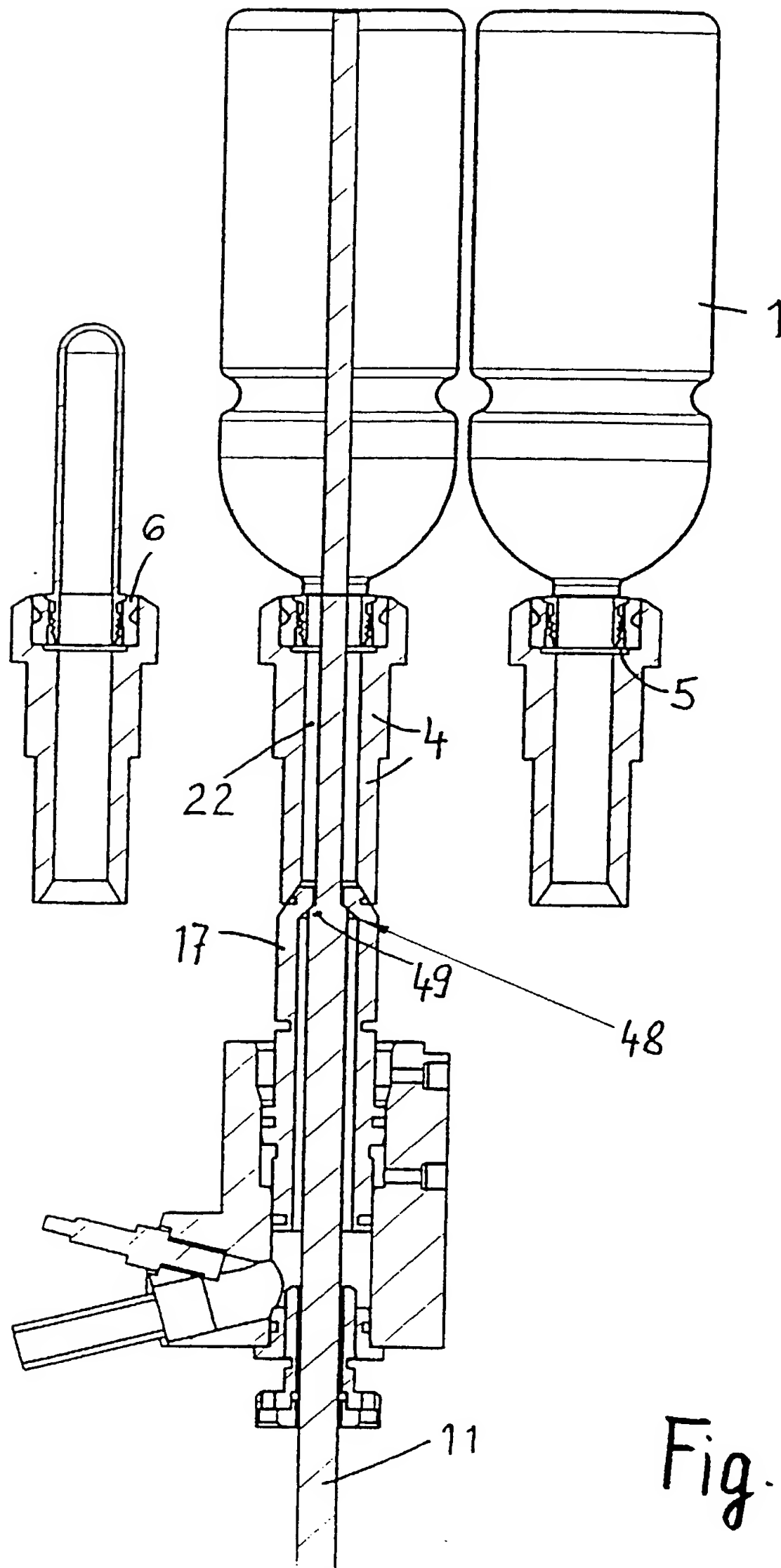


Fig. 10



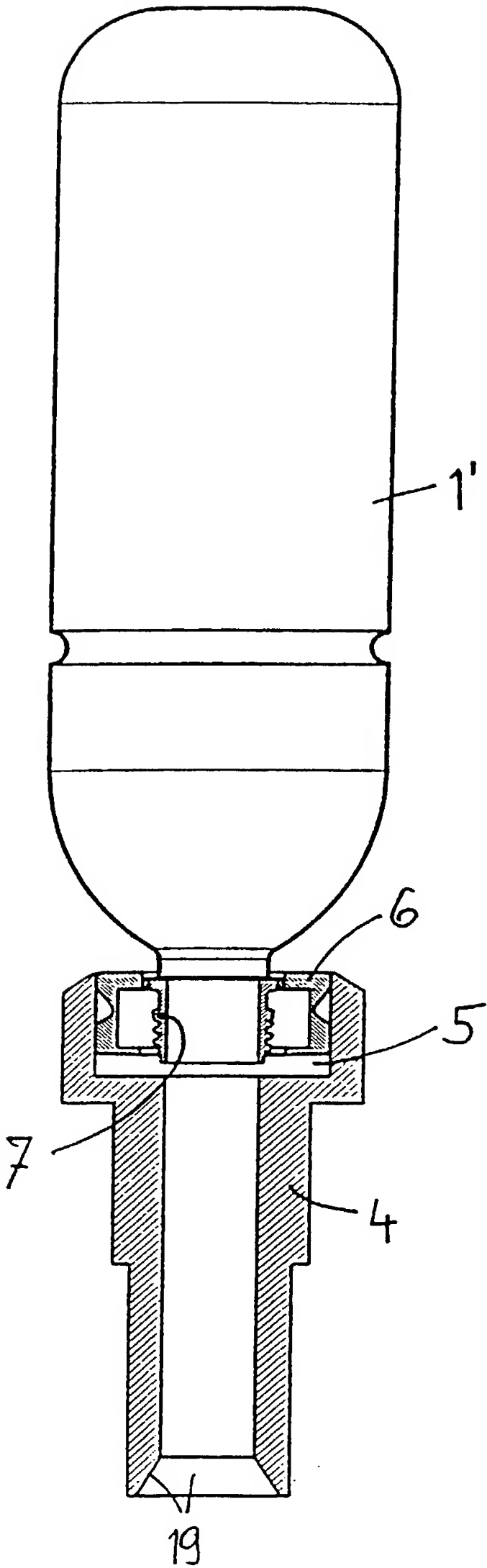


Fig. 12

(12) NACH DEM VERTRAG ÜBER DIE INTERNATIONALE ZUSAMMENARBEIT AUF DEM GEBIET DES
PATENTWESENS (PCT) VERÖFFENTLICHTE INTERNATIONALE ANMELDUNG

(19) Weltorganisation für geistiges Eigentum
Internationales Büro



(43) Internationales Veröffentlichungsdatum
22. Februar 2001 (22.02.2001)

PCT

(10) Internationale Veröffentlichungsnummer
WO 01/12416 A1

(51) Internationale Patentklassifikation⁷: B29C 49/46, 49/12, B29K 67/00, B29L 22/00

(21) Internationales Aktenzeichen: PCT/EP00/06604

(22) Internationales Anmeldedatum:
12. Juli 2000 (12.07.2000)

(25) Einreichungssprache: Deutsch

(26) Veröffentlichungssprache: Deutsch

(30) Angaben zur Priorität:
199 38 724.9 16. August 1999 (16.08.1999) DE

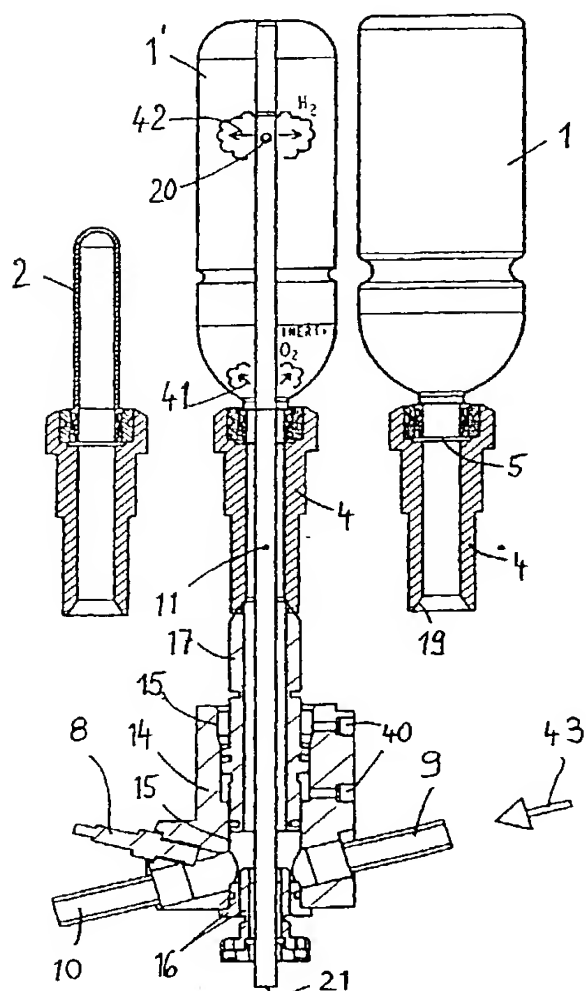
(71) Anmelder (für alle Bestimmungsstaaten mit Ausnahme von US): TETRA LAVAL HOLDINGS & FINANCE S.A. [CH/CH]; 70. avenue Général-Guisan, CH-1009 Pully (CH).

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[Fortsetzung auf der nächsten Seite]

(54) Title: DEVICE FOR THE PRODUCTION OF PLASTIC CONTAINERS BY STRETCH BLOW FORMING USING AN EXPLOSIVE BLOWING MEDIUM

(54) Bezeichnung: VORRICHTUNG ZUR HERSTELLUNG VON KUNSTSTOFFBEHÄLTERN MITTELS STRECKBLASFORMEN UNTER VERWENDUNG EINES EXPLOSIVEN BLASMEDIUMS



(57) Abstract: The invention relates to a device for the production of containers (1) from a plastic material that can be shaped by means of stretch blowing using a mold whose inner space corresponds to the finished container (1), said container being retained by its free ends (7) by a locating part (4), whereby pipes (9, 10) connected to a dosing unit are provided in the locating part (4), a movable stretch die (11) is axially guided through said locating part (4) and an igniting device is mounted to ignite an explosive gas mixture inside the container. Heating and cooling devices are also provided. In order to produce plastic containers with a better appearance, for instance a substantially clear, transparent wall, without requiring additional expenditures, the locating part (4) can be engaged in a solvent-tight manner with the distribution block (14) by the end thereof that faces the container (1), the stretching die (11) being movably guided through said distribution block in the axial extension of the locating part (4) and in which at least one solvent connection (8, 10, 21) is provided, the at least one solvent connection (9, 10, 21) can be closed to seal off the inner space (22) located on the device side and the igniting device is placed in the inner space (22) on the device side.

(57) Zusammenfassung: Beschrieben wird eine Vorrichtung zur Herstellung von Behältern (1) aus einem durch Streck-Blasen verformbaren Kunststoff mit einer Form, deren Innenraum dem fertigen Behälter (1) entspricht, der an seinem offenen Ende (7) von einer Aufnahme (4) gehalten ist, wobei mit einer Dosiereinheit verbundene Leitungen (9, 10) an der Aufnahme (4) vorgesehen sind, ein beweglicher Streckstempel (11) axial durch die Aufnahme (4) geführt ist und eine Zundeinrichtung angeordnet ist, um ein explosives Gasgemisch innerhalb des Behälters zu zünden, und wobei Heiz- und Kühleinrichtungen vorgesehen sind. Um auch Kunststoffbehälter mit besserem Erscheinungsbild herzustellen, zum Beispiel mit weitgehend klar durchsichtiger Wandung, ohne dass grosser Mehraufwand erforderlich ist, wird erfindungsgemäss vorgesehen, dass die Aufnahme (4) an ihrem dem Behälter

[Fortsetzung auf der nächsten Seite]

WO 01/12416 A1

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DECLARATION FOR UTILITY OR DESIGN PATENT APPLICATION (37 CFR 1.63)	Attorney Docket Number		WSP 203 US
	First Named Inventor		Dominique Chatard
	COMPLETE IF KNOWN		
	Application Number	10/049,559	
	Filing Date		
	Art Unit		
<input type="checkbox"/> Declaration Submitted with Initial Filing OR <input checked="" type="checkbox"/> Declaration Submitted after Initial Filing (surcharge (37 CFR 1.16 (e)) required)		Examiner Name	

As the below named inventor, I hereby declare that:

My residence, mailing address, and citizenship are as stated below next to my name.

I believe I am the original and first inventor of the subject matter which is claimed and for which a patent is sought on the invention entitled:

DEVICE FOR THE PRODUCTION OF PLASTIC CONTAINERS BY STRETCH BLOW FORMING USING AN EXPLOSIVE BLOWING MEDIUM

(Title of the Invention)

the specification of which

☐ is attached hereto

OR

☒ was filed on (MM/DD/YYYY)

07/12/2000

as United States Application Number or PCT International

Application Number PCT/EP00/06604 and was amended on (MM/DD/YYYY) (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment specifically referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR 1.56, including for continuation-in-part applications, material information which became available between the filing date of the prior application and the national or PCT international filing date of the continuation-in-part application.

I hereby claim foreign priority benefits under 35 U.S.C. 119(a)-(d) or (f), or 365(b) of any foreign application(s) for patent, inventor's or plant breeder's rights certificate(s), or 365(a) of any PCT international application which designated at least one country other than the United States of America, listed below and have also identified below, by checking the box, any foreign application for patent, inventor's or plant breeder's rights certificate(s), or any PCT international application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application Number(s)	Country	Foreign Filing Date (MM/DD/YYYY)	Priority Not Claimed	Certified Copy Attached?	
				YES	NO
199 38 724.9	Germany	08/16/1999	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

☐ Additional foreign application numbers are listed on a supplemental priority data sheet PTO/SB/02B attached hereto:

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Michael L. Dunn, Dunn & Associates

Name

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716-433-1661

716-433-1665

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Fax

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under 18 U.S.C. 1001 and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

NAME OF SOLE OR FIRST INVENTOR: ☐ A petition has been filed for this unsigned inventor

Given Name Dominique
(first and middle [if any])

Family Name Chatard
or Surname

Inventor's
Signature 

Date 06.04.2002

Residence: City Heidelberg

State

Country Germany
DEX

Citizenship French

Richard-Wagner-Strasse 5

Mailing Address

City Heidelberg

State

ZIP D-69121

Country Germany

NAME OF SECOND INVENTOR: ☐ A petition has been filed for this unsigned inventor

Given Name Jens
(first and middle [if any])

Family Name Fuchs
or Surname

Inventor's
Signature 

Date 14.04.2002

Residence: City Uelversheim

State

Country Germany
DEX

Citizenship German

Guntersblumer Strasse 62a

Mailing Address

City Uelversheim






State

ZIP D-55278

Country Germany

☒ Additional inventors are being named on the 1 supplemental Additional Inventor(s) sheet(s) PTO/SB/02A attached hereto.

DECLARATION	ADDITIONAL INVENTOR(S) Supplemental Sheet Page <u>1</u> of <u>1</u>
--------------------	---

Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
Hans		Kindinger	
Given Name		Family Name or Surname	
Inventor's Signature 		Date 02.04.02	
Wilmshausen		Germany	German
Residence: City	State	Country	Citizenship
Bachgasse 3			
Mailing Address			
Mailing Address			
Wilmshausen		D-646256	Germany
City	State	ZIP	Country
Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
Rolf		Kuhn	
Given Name		Family Name or Surname	
Inventor's Signature 		Date 	
Ingelheim		Germany	German
Residence: City	State	Country	Citizenship
Wackernheimer Strasse 48			
Mailing Address			
Mailing Address			
Ingelheim		D-55218	Germany
City	State	ZIP	Country
Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
Thomas		Riedel	
Given Name		Family Name or Surname	
Inventor's Signature 		Date 	
Biebesheim		Germany	German
Residence: City	State	Country	Citizenship
Albert-Hammann-Strasse 1a			
Mailing Address			
Mailing Address			
Biebesheim		D-64584	Germany
City	State	ZIP	Country

DECLARATION	ADDITIONAL INVENTOR(S) Supplemental Sheet Page <u>1</u> of <u>1</u>
--------------------	---

Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
<div style="display: flex; justify-content: space-between;"> 420 <u>Hans</u> </div> <div style="display: flex; justify-content: space-between;"> Given Name Family Name or Surname </div>		<div style="display: flex; justify-content: space-between;"> <u>Kindinger</u> </div>	
<div style="display: flex; justify-content: space-between;"> <u>Wilmshausen</u> <u>DEX</u> </div> <div style="display: flex; justify-content: space-between;"> Residence: City State Country Citizenship </div>		<div style="display: flex; justify-content: space-between;"> <u>22.09.02</u> </div> <div style="display: flex; justify-content: space-between;"> Date </div>	
<div style="display: flex; justify-content: space-between;"> <u>Bachgasse 3</u> </div> <div style="display: flex; justify-content: space-between;"> Mailing Address </div>			
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Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
<div style="display: flex; justify-content: space-between;"> 810 <u>Rolf</u> </div> <div style="display: flex; justify-content: space-between;"> Given Name Family Name or Surname </div>		<div style="display: flex; justify-content: space-between;"> <u>Kuhn</u> </div>	
<div style="display: flex; justify-content: space-between;"> <u>Ingelheim</u> <u>DEX</u> </div> <div style="display: flex; justify-content: space-between;"> Residence: City State Country Citizenship </div>		<div style="display: flex; justify-content: space-between;"> <u>8.4.02</u> </div> <div style="display: flex; justify-content: space-between;"> Date </div>	
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<div style="display: flex; justify-content: space-between;"> <u>Ingelheim</u> </div> <div style="display: flex; justify-content: space-between;"> City State ZIP Country </div>		<div style="display: flex; justify-content: space-between;"> <u>D-55218</u> </div>	
Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
<div style="display: flex; justify-content: space-between;"> <u>Thomas</u> </div> <div style="display: flex; justify-content: space-between;"> Given Name Family Name or Surname </div>		<div style="display: flex; justify-content: space-between;"> <u>Riedel</u> </div>	
<div style="display: flex; justify-content: space-between;"> <u>Biebesheim</u> <u>DEX</u> </div> <div style="display: flex; justify-content: space-between;"> Residence: City State Country Citizenship </div>		<div style="display: flex; justify-content: space-between;"> <u>8.4.02</u> </div> <div style="display: flex; justify-content: space-between;"> Date </div>	
<div style="display: flex; justify-content: space-between;"> <u>Albert-Hammann-Strasse 1a</u> </div> <div style="display: flex; justify-content: space-between;"> Mailing Address </div>			
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POWER OF ATTORNEY OR AUTHORIZATION OF AGENT	Application Number	10/049,559
	Filing Date	
	First Named Inventor	Dominique Chatard
	Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
	Group Art Unit	Not yet assigned
	Examiner Name	Not yet assigned
	Attorney Docket Number	WSP 203 US

I hereby appoint:

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Name	Registration Number
Michael L. Dunn	25,330
Howard M. Ellis	25,856
Robert P. Simpson	33,034

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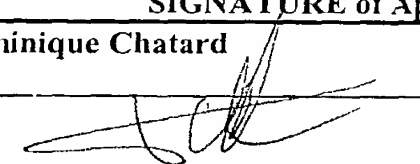
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Michel L. Dunn Dunn & Associates	
Address	P.O. Box 10
Address	
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Zip	14108
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Telephone	716-433-1661
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I am the:

☒ Applicant/Inventor.
☐ Assignee of record of the entire interest. See 37 CFR 3.71.
 Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).

SIGNATURE of Applicant or Assignee of Record

Name	Dominique Chatard
Signature	
Date	06.04.2002

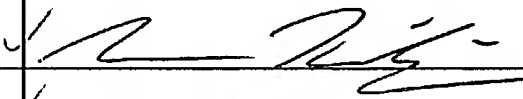
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<p style="text-align: center;">POWER OF ATTORNEY OR AUTHORIZATION OF AGENT</p>	Application Number	10/049,559
	Filing Date	
	First Named Inventor	Dominiaue Chatard
	Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
	Group Art Unit	Not yet assigned
	Examiner Name	Not yet assigned
	Attorney Docket Number	WSP.203 US

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Howard M. Ellis		25,856			
Robert P. Simpson		33,034			
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<input type="checkbox"/> Practitioners at Customer Number <input type="text"/>					
<input checked="" type="checkbox"/> Firm or Individual Name		Michel L. Dunn Dunn & Associates			
Address		P.O. Box 10			
Address					
City		Newfane	State	New York	Zip 14108
Country		U.S.A.			
Telephone		716-433-1661	Fax	716-433-1665	
I am the:					
<input checked="" type="checkbox"/> Applicant/Inventor.					
<input type="checkbox"/> Assignee of record of the entire interest. See 37 CFR 3.71. Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).					
SIGNATURE of Applicant or Assignee of Record					
Name		Hans Kindinger			
Signature					
Date		02.04.02			
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Address

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☒ Applicant/Inventor.

☐ Assignee of record of the entire interest. See 37 CFR 3.71.
Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).

SIGNATURE of Applicant or Assignee of Record

Name	Rolf Kuhn
------	-----------

Signature

Date _____

NOTE: Signatures of all the inventors or assignees of record of the entire interest or their representative(s) are required. Submit multiple forms if more than one signature is required, see below*.

☒ *Total of 88 forms are submitted

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<p>POWER OF ATTORNEY OR AUTHORIZATION OF AGENT</p>	Application Number	10/049,559
	Filing Date	
	First Named Inventor	Dominiaue Chatard
	Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
	Group Art Unit	Not yet assigned
	Examiner Name	Not yet assigned
	Attorney Docket Number	WSP 203 US

I hereby appoint:

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☒ Practitioner(s) named below:

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Name	Registration Number
Michael L. Dunn	25,330
Howard M. Ellis	25,856
Robert P. Simpson	33,034

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<input checked="" type="checkbox"/> Firm or Individual Name	Michel L. Dunn Dunn & Associates				
Address	P.O. Box 10				
Address					
City	Newfane	State	New York	Zip	14108
Country	U.S.A.				
Telephone	716-433-1661	Fax	716-433-1665		

I am the:

☒ Applicant/Inventor.

☐ Assignee of record of the entire interest. See 37 CFR 3.71.
Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).

SIGNATURE of Applicant or Assignee of Record

Name	Thomas Riedel
Signature	
Date	06.04.02

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**POWER OF ATTORNEY OR
AUTHORIZATION OF AGENT**

Application Number	10/049,559
Filing Date	
First Named Inventor	Dominique Chatard
Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
Group Art Unit	Not yet assigned
Examiner Name	Not yet assigned
Attorney Docket Number	WSP.203 US

I hereby appoint:

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Michael L. Dunn	25,330
Howard M. Ellis	25,856
Robert P. Simpson	33,034

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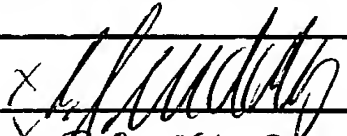
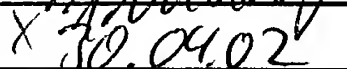
- ☒ Firm or Individual Name
- Michel L. Dunn
Dunn & Associates

Address	P.O. Box 10				
Address					
City	Newfane	State	New York	Zip	14108
Country	U.S.A.				
Telephone	716-433-1661	Fax	716-433-1665		

I am the:

- ☒ Applicant/Inventor.
- ☐ Assignee of record of the entire interest. See 37 CFR 3.71.
Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).

SIGNATURE of Applicant or Assignee of Record

Name	Eberhard Sendobry
Signature	
Date	

NOTE: Signatures of all the inventors or assignees of record of the entire interest or their representative(s) are required. Submit multiple forms if more than one signature is required, see below*.

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**POWER OF ATTORNEY OR
AUTHORIZATION OF AGENT**

Application Number	10/049,559
Filing Date	
First Named Inventor	Dominiauc Chatard
Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
Group Art Unit	Not yet assigned
Examiner Name	Not yet assigned
Attorney Docket Number	WSP:203 US

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Name	Registration Number
Michael L. Dunn	25,330
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- ☒ Firm or Individual Name
- Michel L. Dunn
Dunn & Associates

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Address						
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Statement under 37 CFR 3.73(b) is enclosed. (Form PTO/SB/96).

SIGNATURE of Applicant or Assignee of Record

Name	Rudiger Wlach
Signature	X R. Wlach
Date	X 02-05-2002

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**POWER OF ATTORNEY OR
AUTHORIZATION OF AGENT**

Application Number	10/049,559
Filing Date	
First Named Inventor	Dominique Chatard
Title	Device for the Production of Plastic Containers by Stretch Blow Forming Using an Explosive Blowing Medium
Group Art Unit	Not yet assigned
Examiner Name	Not yet assigned
Attorney Docket Number	WSP-203 US

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<input checked="" type="checkbox"/> Firm or Individual Name	Michel L. Dunn Dunn & Associates				
Address	P.O. Box 10				
Address					
City	Newfane	State	New York	Zip	14108
Country	U.S.A.				
Telephone	716-433-1661	Fax	716-433-1665		

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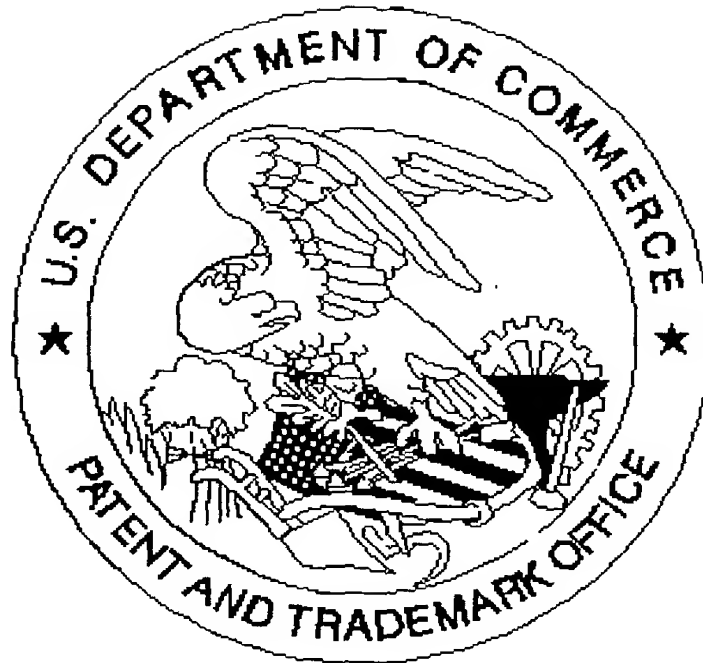
Name	Lothar Wilhelm
Signature	X 
Date	X 30.4.02

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